Guide 36

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Drilling Rig Requirements and Inspection Guide

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PROPOSED CHANGES TO EUB *GUIDE 36*

Existing Requirements	Proposed Changes - General	Rationale
The current blowout prevention requirements related to drilling wells in Alberta are detailed in sections 8.130 to 8.143 of the Oil and Gas Conservation Regulations as well as in various other EUB documents (guides, informational letters, interim directives, and general bulletins).	All EUB blowout prevention requirements and procedures related to drilling wells in Alberta will now be detailed in draft *Guide 36*. The guide also contains references to other requirements applicable to drilling operations, e.g. ERP requirements. Rescind or modify other EUB documents (informational letters, interim directives, and general bulletins) that will be redundant.	Requirements have been consolidated into one document for clarity, consistency and ease of access. In addition, to reduce any possible conflicts with other EUB documents. Also Industry requested that all requirements be located in one document.
	Draft *Guide 36* updates and adds to the blowout prevention equipment requirements and procedures for drilling operations as detailed below.	To reflect existing equipment and new technology that is now available to the drilling industry. Items that were open to interpretation have been clarified. The intent of all proposed changes is to minimize blows and blowouts.
Existing *Guide 36* refers to noncompliance items as significant and serious rather than minor/major/serious.	Draft *Guide 36* details noncompliance items as minor/major/serious. Additionally, to identify consequences for noncompliance as per the EUB's enforcement ladder process, detailed in *Informational Letter (IL) 99-4: EUB Enforcement Process, Generic Enforcement Ladder, and Field Surveillance Enforcement Ladder*.	To align draft *Guide 36* with the existing enforcement ladder process.

Section of draft *Guide 36*	**Proposed Changes - Specific**	**Rationale**
	1. Blowout Prevention System	
1.1.5 Double Drilling/Studding *(Existing Guide 36 - Section 210 (4))*	Studding flanged equipment to accommodate connections to other API equipment that may have a lower pressure rating results in a derating of the flange to the lower working pressure. If a studded flange is used in an application requiring its original pressure rating, documentation must be provided from either the original equipment manufacturer (OEM) or a professional engineer (P. Eng.) that the flange is certified for the higher-pressure rating.	This proposed requirement recognizes that studding of flanged Blowout Preventer (BOP) equipment may derate the working pressure of the flange causing a failure at a lower pressure.
1.2 Casing Bowls *(New)*	Class I wells may use sliplock type, threaded, or weld-on casing bowls. For well classes II to VI, only threaded or weld-on casing bowls are permitted.	Specifies minimum casing bowl requirements for all well classes to ensure the appropriate type of casing bowl is used.
1.4 Stabbing Valve and Inside BOP *(New)*	For well classes V and VI, the stabbing valve must be certified by the OEM or a P.Eng. as being capable of opening with 7000 kilopascals (kPa) pressure below the valve. For coiled tubing units where the bottomhole assembly can be fully lubricated into or out of the well (no staged deployment), a stabbing valve is not required. For coiled tubing units, there is no requirement for an inside BOP.	High pressures at surface may be encountered during the drilling of class V and VI wells. This requirement will ensure the stabbing valve opens under pressure. Where there is no staged deployment a stabbing valve serves no function. As coiled tubing units have a continuous drill string, an inside BOP serves no function.
1.5 Lower Kelly Cock Valve *(New)*	For well classes V and VI, the kelly must be equipped with a lower kelly cock valve.	Provides the ability to isolate surface pumping equipment from the high pressures that may be encountered on these types of wells.
1.7 Shop Servicing and Testing of BOPs, BOP Spools, and Flexible Bleed-off and Kill-line Hoses *(Regulation 8.141 (7), existing Guide 36 - Section 275 (4, 5 and 6) and IL 88-11 Shop Servicing And Testing Of Blowout Preventers and Flexible Bleed-Off and Kill-Line Hoses)*	BOP spools have been added to 3-year shop servicing requirements. All shop servicing work and testing must be conducted under the supervision of an OEM designate or a certifying P. Eng. Storage and documentation requirements are specified.	These minimum requirements have been added to ensure competent job servicing and testing is being conducted. Three-year shop service and testing requirements have been revised in collaboration with the Canadian Association of Oilwell Drilling Contractors (CAODC).

2. Bleed-off and Kill Systems

2.1.1.1 **Diverter Line - Class I Wells** *(New)*	The diverter line must have a working pressure at least equal to that of the required BOP system. The diverter line connections must be flanged, hammer union, or threaded (eliminates the use of Bauer-type connections, etc.). The HCR must be connected directly to the drilling spool (no fluid turns or pipe extensions).	Minimum requirements are specified to ensure the integrity of this line, as it is crucial during well control situations. Will reduce the potential for washouts between the valves and the drilling spool in the event of a well control situation.

2.1.2.1 **Bleed-off Line(s) – Well Classes II to VI and Critical Sour Wells** *(New)*	Piping extensions or fluid turns are not permitted between the drilling spool, HCR, or manual valve(s). Valves must be flanged together and connected directly to the drilling spool.	Will reduce the potential for washouts between the valves and the drilling spool in the event of a well control situation.
2.1.2.2 **Choke Manifold** *(New)* *(Existing Guide 36 - Section 210 (14))*	All chokes must be labelled to identify the fully open and the fully closed positions. If intermediate casing has been set, the maximum readable increments on the choke manifold casing pressure gauge(s) have been increased from 250 kPa to 500 kPa. The range of the casing pressure gauge must not be less than the pressure rating of the required BOP system.	In the event of a well control situation the choke position must be known for proper operation. With the higher holdback pressures allowed by intermediate casing a higher range gauge is suitable.
2.1.2.3 **Flare Line(s)** *(New)*	The flare line must have (as a minimum) a working pressure equal to that of the required BOP system.	Minimum requirements are specified to ensure the integrity of this line, as it is crucial during well control situations.
2.1.2.4(c) **Degasser Inlet** *(New)*	The degasser inlet line must have (as a minimum) a working pressure equal to that of the required BOP system. The degasser inlet line must be accessible full length, and no portion of the line may be submerged in drilling fluid.	Minimum requirements are specified to ensure the integrity of this line, as it is crucial during well control situations. To allow for visual inspection of this line.
2.1.2.4(d) **Degasser Vent Line** *(New)*	The vent line must be accessible full length, and no portion of the line may be submerged in drilling fluid.	To allow for visual inspection of this line.
2.2.2 **Well Classes II-IV** *(New)*	Piping extensions or fluid turns are not permitted between the drilling spool and the first manual valve. This valve must be connected directly to the drilling spool. The kill line valve next to the drilling spool must be in the closed position during normal drilling operations.	To eliminate the potential for buildup of solids between the spool and the manual valve.

2.2.2.1 **Well Classes V and VI and Critical Sour Wells** *(New)*	For well classes V and VI, a flanged check valve must be installed on each kill line.	To provide the ability to isolate surface pumping equipment from the high pressures that may be encountered on these types of wells in a well control situation.

3. Flexible Hoses

3.1 **Bleed-off, Kill, or Diverter Line(s)**		
(Regulation 8.135(6) and existing Guide 36 - Section 210 (23))	Flexible hoses used in the bleed-off, kill, or diverter line(s) must be fire sheathed if used within 7 m of the well.	This requirement for fire sheathing will protect the flexible hoses within 7 m of the well. (This requirement is now consistent with 7m requirement for BOP hydraulic hoses).
(New)	Adequate fire-resistant sheathing for flexible hoses used in the bleed-off, kill, or diverter line(s) is defined as a hose assembly that can withstand a minimum of 30 minutes of 700°C flame temperature at maximum working pressure without failure.	Defines adequate fire sheathing to ensure clarity and is consistent with Lloyds of London testing requirements for flexible hoses used in the bleed-off, kill, or diverter line(s).
3.2 **Flare and Emergency Flare Line(s)** *(New)*	Flexible hoses used in the flare and emergency flare line(s) must be fire sheathed if used within 7 m of the well.	This requirement for fire sheathing will protect the flexible hoses within 7 m of the well. (This requirement is now consistent with 7m requirement for BOP hydraulic hoses).
	Adequate fire-resistant sheathing for flexible hoses used in the flare or emergency flare line(s) is defined as a hose assembly that can withstand a minimum of 30 minutes of 700°C flame temperature at maximum working pressure without failure.	Defines adequate fire sheathing to ensure clarity and is consistent with Lloyds of London testing requirements for flexible hoses used in the flare or emergency flare line(s).

5. BOP Control Systems

5.1 **Accumulator System**		
(Regulation 8.133 and existing Guide 36 - Sections 215(5), (6) and 235 (1)	For class I wells, the accumulator system must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the hydraulically operated valve (HCR) on the bleed-off line, close the annular preventer on drill pipe, and retain a minimum pressure of 8400 kPa on the accumulator system.	To allow for automatic recharge of the accumulator (to eliminate human error) and is consistent with accumulator requirements for all other well classes.
(New)	When a coiled tubing unit (CTU) is used to drill a class II, III, or IV well, the accumulator system must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line.	To ensure sufficient accumulator volume and pressure to function and maintain closure of the BOPs.

	close the annular preventer, on the drill pipe, close one ram preventer, and retain a minimum pressure of 8400 kPa on the accumulator system. In addition to the above functions, the accumulator system for CTUs must also provide sufficient volume and pressure to shear the coiled tubing and retain on the accumulator system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.	
(New)	When a CTU is used to drill a class V or VI well, the accumulator system must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close two ram preventers, and retain a minimum pressure of 8400 kPa on the accumulator system. In addition to the above functions, the accumulator system for CTUs must also provide sufficient volume and pressure to shear the coiled tubing and retain on the accumulator system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.	To ensure sufficient accumulator volume and pressure to function and maintain closure of the BOPs.
(ID 97-6 Sour Well Licensing and Drilling Requirements - Section 4.3.1(5))	For critical sour wells, the accumulator system must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close, open, and close one ram preventer, and if blind/shear rams are installed, provide sufficient volume and pressure to shear the drill pipe and retain on the accumulator system a minimum pressure of 8400 kPa or the minimum pressure required to shear the drill pipe, whichever is greater. If the existing accumulator system cannot meet these requirements because of the addition of the blind/shear rams, the accumulator system's capacity and/or pressure must be increased or a separate accumulator system must be installed. It is also acceptable to supplement the existing accumulator system with a nitrogen (N_2) booster that will provide sufficient volume and pressure to shear the drill pipe and retain a minimum accumulator pressure of 8400 kPa or the minimum pressure required to shear the drill pipe, whichever is greater.	To ensure sufficient accumulator volume and pressure to function and maintain closure of the BOPs.
(Regulation 8.133 (2)(c) and Existing Guide 36 - Section 215(6))	All non-steel accumulator hydraulic lines located within 7 m of the wellbore must be completely sheathed with adequate fire-resistant sheathing.	This requirement for fire sheathing will protect the non-steel accumulator hydraulic lines within 7 m of the well.
(New)	Adequate fire-resistant sheathing for hydraulic BOP hoses is defined as a hose assembly that can withstand a minimum of 5 minutes of 700°C flame temperature at maximum working pressure without failure.	Defines adequate fire sheathing to ensure clarity and is consistent with Lloyds of London testing requirements for hydraulic BOP hoses.

(New)	For well classes V and VI and critical sour wells, the accumulator system must be equipped with two separate automatic pressure-controlled recharge pumps.	For deeper higher pressure wells the addition of a second pump provides a back up recharge system to ensure adequate accumulator system pressure for well control. Consistent with *IRP 1: Critical Sour Drilling* and *API RP 53: Recommended Practices for Blowout Prevention Equipment Systems for Drilling Wells.*

5.2 Backup Nitrogen (N_2) System *(New)*	When a CTU is used to drill a class II, III, and IV well, the back-up N_2 system must be capable of providing N_2 of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close one ram preventer, and retain a minimum pressure of 8400 kPa on the backup N_2 system.	To ensure sufficient N_2 volume and pressure to function and maintain closure of the BOPs.
	When a CTU is used to drill a class V or VI well, the backup N_2 system must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close two ram preventers, and retain a minimum pressure of 8400 kPa on the accumulator system. In addition to the above functions, CTUs drilling well classes II, III, IV, V, and VI must also provide sufficient volume and pressure to shear the coiled tubing and retain on the backup N_2 system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.	To ensure sufficient N_2 volume and pressure to function and maintain closure of the BOPs.
	For critical sour wells, the backup N_2 system must be capable of providing N_2 of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close, open, and close one ram preventer, and if blind/shear rams are installed, provide sufficient volume and pressure to shear the drill pipe and retain on the backup N_2 system a minimum pressure of 8400 kPa or the minimum pressure required to shear the drill pipe, whichever is greater. For critical sour wells, if the existing backup N_2 system cannot meet these requirements because of the addition of the blind/shear rams, the backup N_2 system's capacity and/or pressure must be increased or a separate backup N_2 system must be installed. It is also acceptable to supplement the existing backup N_2 system with an N_2 booster (this may be the same N_2 booster system that supplements the accumulator).	To ensure sufficient N_2 volume and pressure to function and maintain closure of the BOPs.

5.3.1 Floor Controls *(New)*	A gauge indicating the accumulator system pressure must be available at the floor controls.	To allow for monitoring accumulator system pressure on the rig floor, as it is critical for BOP operation.
5.3.2 Remote Controls *(New)*	The BOP remote operating controls must be capable of opening each BOP component.	When a BOP has to be opened during a well control situation, it is safer to open the BOP from the remote position.

6. Pressure Testing

6.1.2 **Well Classes II to VI and Critical Sour Wells** *(New)*	Low-pressure tests are required on • annular • bleed-off line and valves • manifold valves • kill line and valves • stabbing valve • inside BOP • lower kelly cock • surface casing	Currently low-pressure testing is only required on ram-type BOPs. Proposed change would add requirement for low-pressure tests on items identified in column two. This is a common industry practice and is consistent with *API RP 53: Recommended Practices for Blowout Prevention Equipment Systems for Drilling Wells.*

7. Engines

7.1.2 **Gasoline Engine(s)** *(New)*	Any gasoline (including propane-powered) engine operating within 25 m of a well during the drilling operation must be equipped with an ignition shutoff device equipped with a remote control readily accessible at the driller's station or another approved device.	Currently gasoline engines are not identified as a source of ignition in *Guide 36*. By adding gasoline engines to existing requirements will ensure consistency with Schedule 11 of Regulations.

8. Mud Tanks and Fluid Volume Monitoring Systems

8.1 **Mud Tanks** *(New)*	All wells being drilled must have mud tanks with an appropriate mud tank fluid volume monitoring system.	Mud tanks equipped with a monitoring system are required to ensure accurate fluid volume monitoring to allow for kick detection and maintaining well control. Current wording in the Regulations implies mud tanks are an option.
8.2.2 **Automated (Electronic) Mud Tank Fluid Volume Monitoring System** *(New)*	All wells drilled with oil-based drilling fluids, must have an automated mud tank fluid volume monitoring system that is electronically operated.	When drilling with oil-based drilling fluids, kick detection is difficult due to the solubility of hydrocarbons in oil-based drilling fluids. An electronic system more accurately measures gains and losses in the fluid system.
8.3 **Trip Tank—Design and Fluid Level Monitoring** *(New)*	Well classes I and II must have a trip tank with a fluid level monitoring system.	A trip tank equipped with a fluid level monitoring system is required for kick detection. This is consistent with trip tank requirements for well classes III, IV, V, and VI.

9. Well-Site Supervision and Certification

9.1 **Well-Site Supervision** *(New)*	For each drilling operation the licensee must provide a qualified well-site representative who is responsible for the supervision of the drilling operations and a qualified rig manager who is responsible for the supervision of the drilling rig. These two individuals must be readily available and cannot supervise other drilling/servicing operations at the same time.	These individuals are required because in the event of a well control situation, the duties of the well-site representative and rig manager would not allow them to adequately supervise other operations.

10. Well Control, Crew Training, and Tripping

10.1 **Well Control** *(New)*	The licensee must ensure that sufficient drilling fluid density is maintained at all times to control formation pressures throughout the drilling of the well.	Sufficient fluid density is essential for well control (overbalanced drilling).
10.1.2 **Reduced Speed Pump Pressure (RSPP)** *(New)*	For well classes II to VI, when potential hydrocarbon-bearing zones have been penetrated, the reduced pump speed and the reduced pump pressure that will be used to circulate out a kick from the wellbore must be recorded in the drilling logbook at least once per tour.	The crew requires this information to control the well in the event of an influx of wellbore fluids.
10.3 **Tripping** *(New)*	For all well classes, prior to tripping pipe from the well, the drilling fluid density must be adequate to exert a sufficient trip margin that will ensure an overbalance of the expected formation pressures so that formation fluids do not enter the wellbore.	This requirement will reduce the potential of an influx of wellbore fluids.
10.3.1 **Flow Checks**		
(New)	Prior to conducting a flow check, the hole must be filled to surface.	Essential to fill hole to surface to properly conduct a flow check.
(Regulation 8.137 (5) and ID 92-1 Drilling Blowout Prevention Modification - Section 1.3.1)	10-minute flow checks must be conducted while tripping pipe into and out of the well.	The current requirement of 5-minute flow checks is not sufficient to properly detect a kick.
	For critical sour wells the flow check requirements have been modified to be consistent with those set out in *ID 92-1: Drilling Blowout Prevention Requirements Modification*. The flow check requirements in ID 92-1 have been incorporated into this section of Draft Guide 36.	The flow check requirements were modified to improve the ability to detect a kick when tripping pipe into or out of the well.

12. Casing Inspection

12.2.3 **Logging the Casing** *(Regulation 8.141 (3)(a) and Existing Guide 36 – Section 285 (5))*	Surface/intermediate casing must be logged using a log or a combination of logs, fully interpreted on a joint-by-joint basis. These logs must determine the percentage (%) penetration of anomalies, distinguish between internal and external corrosion, and detect holes, pits, perforations, metal loss, and metal thickness.	This logging requirement will be consistent with the casing logging requirements set out in *Guide 51: Injection and Disposal Wells – Well Classifications, Completions, Logging, and Testing Requirements*.

13. Drillstem/Well Testing

13.1 Drillstem Testing (DST) *(New)*	A separate DST line(s) must be installed for testing purposes, and the end of the line(s) must terminate at least 50 m from the well.	Prevent wear and washout on the main bleed-off system.
	The DST line(s) must be secured at 10 m intervals. Stakes or weights must be used, as dictated by the soil conditions.	Consistent with all other requirements regarding securing of bleed-off and/or flare lines.
	The DST manifold must have, as a minimum, the same pressure rating as the required BOP system.	DST equipment is subjected to the same formation pressures that the required BOP system would be exposed to.
	The DST manifold must be secured.	The DST equipment must be properly secured to restrict it from movement.
	If liquids are produced during a DST, the liquids must be separated and must not be directed to an earthen pit.	Prevent the contamination of soil and ground water and consistent with *IRP 4: Well Testing and Fluid Handling*.

14. High-Hazard Area and Surface Casing Reductions

14.1.3 and 14.2.1 Emergency Flare Line *(Regulation 8.129 (10)(b), ID 92-1 Drilling Blowout Prevention Modification – Section 1.6 and Guide 8 Surface Casing Depth Minimum Requirements- Section 1)*	In the High-Hazard Area (Southeastern Alberta), and where Type 3 and Type 4 surface casing reductions (*Guide 8 – Surface Casing Depth Minimum Requirements*) have been applied, an emergency flare must be installed (see Figure 4). Elimination of the exemption from running an emergency flare line if no fluid turns or flexible hose exist in the section of the bleed-off line between the BOP stack and the choke manifold.	Two bleed-off lines will be required as a single bleed-off line may not be sufficient for potential wellbore pressures/flows that may be encountered.
(New)	The emergency flare line valves must be flanged together and connected directly to the drilling spool. (Piping extensions or fluid turns are not permitted between the drilling spool and the two valves.)	Will reduce the potential for washouts between the valves and the drilling spool in the event of a well control situation.
(New)	A flanged outlet on the lower ram preventer may be substituted in place of the lower drilling spool.	Provides for flexibility with BOP configuration when stack height is too tall for the sub-structure.

15. Sour and Critical Sour Wells

15.4.3 **BOP System and Choke Manifold** *(New)*	When BOP Configuration 2 or BOP Configuration 3 is used, an appropriately sized ram-blanking tool that fits into the top pipe ram must be on location and readily available.	This allows the top pipe ram to perform the function of a blind ram when the drill string is out of the hole allowing use of both the primary and secondary bleed-off lines during a well control event. This requirement introduces a safety factor by making the second bleed-off line functional.
15.4.7 **H_2S Monitoring** *(New)*	Minimum pH requirements are now identified, when water-based drilling fluid is in use. The pH must be maintained at 10.5 or greater.	Reduces the potential for sulphide stress cracking and is consistent with *IRP 1: Critical Sour Drilling*.
15.4.8 **Sulphide Monitoring**		
(ID 97-6 Sour Well Licensing and Drilling Requirements - Section 4.3.6(2))	When drilling in the critical sour zone with water-based drilling fluid, H2S scavenger must be added whenever sulphides are detected. When no soluble sulphides are detected in the filtrate, the licensee may revert back to continuous sulphide monitoring or hourly HACH tests.	The addition of H_2S scavenger is now required to reduce sulphides to protect the pipe. This requirement is consistent with *IRP 1: Critical Sour Drilling*.
(New)	When drilling in the critical sour zone with oil-based drilling fluid, the drilling fluids must be tested using a modified Garrett Gas Train Test (GGTT) a minimum of three times per day on the whole drilling fluid.	Reduces the potential for sulphide stress cracking and is consistent with *IRP 1: Critical Sour Drilling*.
(New)	If soluble sulphides are detected in the whole oil-based mud by the modified GGTT, the frequency of the modified GGTT must be increased to every two hours and the appropriate amount of H_2S scavenger must be added to ensure that there are no soluble sulphides in the whole oil-based mud. When no soluble sulphides are detected in the whole oil-based mud, the licensee may revert back to the modified GGTT three times per day.	

16. Well-Site Records and Reporting

16.5 **Directional Surveys—Critical Sour Wells**	Prior to entering the critical zone, a directional survey (azimuth and inclination) is required.	The survey is necessary to determine the azimuth and inclination of the wellbore prior to entering the critical zone as this information will be needed in the event that a relief well is required.
(ID 97-6 Sour Well Licensing and Drilling Requirements - Section 4.4.2(2))	After penetration of the critical zone, directional surveys (azimuth and inclination) must be conducted at maximum intervals of 150 m when the wellbore has an inclination less than 3°. If the inclination is greater than 3°, a directional survey must be conducted at maximum intervals of 60 m.	When the inclination is greater than 3° additional surveys are required.

17. Licensee and Contractor Inspections

17.2 **Detailed Inspections** *(New)*	For wells without surface casing set (class I wells or wells that require a diverter system), a detailed inspection must be conducted prior to the commencement of drilling operations, (vs. the requirement of not having to conduct an inspection on a class II to VI well until after surface casing is set).	The detailed inspection will help ensure that the licensee has met all requirements of the guide prior to commencement of drilling operations.

18. Well-Site Fluids and Environment

18.1 **Invert Mud Systems** *(New)*	Make-up reserve for hydrocarbon-based drilling fluid must be stored a minimum of 25 m from the well.	To ensure the make-up reserve tank is located a safe distance from the well in the event of a fire.
18.2 **Crude Oil Used to Release Stuck String (Spotting)** *(New)*	The licensee must address the on-site safety procedures when crude oil is used for releasing stuck drill string (spotting) before commencing this operation. The crude oil must dead oil and contain no H_2S.	This is necessary due to the inherent dangers associated with using crude oil to release stuck drill pipe. Usage of sweet dead oil will reduce odours and ensure safety.

21. Drilling with a Service Rig and Servicing with a Drilling Rig

21.1.1 **Drilling More Than 50 m or More Than One Hydrocarbon-Bearing Formation** *(New)*	When the licensee is conducting drilling operations with a service rig, the operation is classified as a drilling operation if **more** than 50 m measured depth of new hole will be drilled or **more** than one potential hydrocarbon-bearing formation will be penetrated.	Currently the drilling interval of 50 m or penetration of more than one hydrocarbon-bearing zone is not identified as a drilling operation in the existing requirements. This requirement defines the difference between drilling and servicing operations.

22. Coiled Tubing

22 **Coiled tubing** *(New)*	Minimum BOP configurations to be used when drilling with coiled tubing are identified.	These requirements are specified because they did not exist at the time the current *Guide 36* was published. These requirements will ensure consistency existing minimum BOP requirements for all well classes.

Appendix 3 - Blowout Prevention Systems

Appendix 3 *(Schedule 8 of the Regulations and Regulation 8.131, Appendix 1010 of Existing Guide 36)*	The existing Class 1A BOP system replaces the existing Class 1 BOP system and has been renamed Class I. The minimum Class I BOP system pressure rating set at 3500 kPa.	Simplifies the minimum BOP requirements for Class I wells and clarifies the required minimum pressure rating. The existing Class I and Class IA configuration did not specify a minimum pressure rating.
	The proposed Class II BOP stack configuration now matches the Class III BOP stack configuration, with the exception of the pressure rating, which is set at 7000 kPa for the proposed Class II (the existing requirement is 14000 kPa).	The proposed stack configuration will allow the well to be bled-off with the drill string out of the hole and the blind rams closed. The existing Class II BOP configuration placed the blind ram below the drilling spool. This would not allow wellbore fluids to be bled-off through the spool if the well needed to be shut-in with the drill string out of the hole. A minimum BOP system pressure rating of 7000 kPa should be adequate for wells that have a true vertical depth of less than 750m.
	Class V BOP stack configuration has been corrected to indicate the requirement for two sets of pipe rams.	This will correct an omission of the requirement for the second set of pipe rams in the existing *Guide 36*. The requirement for a second set of pipe rams on a Class V well is shown in Schedule 8 of the Regulations.
	The Class V and VI BOP stack configurations have been revised and are now consistent with those that are required for drilling critical sour wells.	The revised BOP stack configurations allow for more functionality of all blowout prevention equipment when bleeding-off or killing the well.
	The emergency flare line for Class V and VI wells has been eliminated. Class V and VI choke manifold requirements have been changed to include two bleed-off lines (from the drilling spools) into two separate manifold wings and two flare lines out of the manifold to the flare pit.	Allows for greater flexibility of the bleed-off system during a well control situation.

Appendix 4 – NACE Requirements for Metallic Materials Exposed to H_2S

Appendix 4 *(New)*	For non-critical sour wells, recommendations are introduced where deployment of NACE standard surface pressure control equipment should be considered.	Clarification that the EUB does not require pressure containing components of the BOP and bleed-off and kill systems to meet NACE standard material requirements for non-critical sour wells.

CONSEQUENTIAL CHANGES THAT WILL BE REQUIRED TO OTHER EXISTING EUB DOCUMENTS IF THE PROPOSED CHANGES TO EUB GUIDE 36 ARE IMPLEMENTED

EUB DOCUMENT	PROPOSED CHANGE
Guide 8 – *Surface Casing Depth Minimum Requirements*	Section 2, Figure 7 – Emergency Flare-line Configuration for Type-3 and Type-4 Reductions of Guide 8 will be replaced with Figure 4 of Section 14 - *High-Hazard Area and Surface Casing Reductions* of draft Guide 36 *Drilling Rig Inspection Manual.*
General Bulletin GB 98-13 – *Minimum Standards For Flare Tanks*	GB 98-13 has been modified and incorporated in Section 2.1.4 *Flare Tanks* of draft Guide 36. GB 98-13 will be rescinded.
General Bulletin GB 98-28 – *Well Stripping Operations*	GB 98-28 has been modified and incorporated in Section 1.6 *Stripping Operations* of draft Guide 36. GB 98-28 will be rescinded.
Interim Directive ID 92-1 – *Drilling Blowout Prevention Requirements Modification*	The requirements of ID 92-1 (in its entirety) have been modified and incorporated into the draft Guide 36, specifically; Section 1.2 *Kick Prevention* of ID 92-1 is incorporated in Section 10.1.4 *STICK Diagram* of draft Guide 36. Section 1.3 *Kick Detection* of ID 92-1 has been modified and incorporated in Section 8 *Mud Tank and Fluid Volume Monitoring Systems* and Section 10.3.1 *Flow Checks* of draft Guide 36. Section 1.4 *Bleed-Off Equipment Integrity* of ID 92-1 has been incorporated into Section 2.1.1.1 *Diverter Line*, Section 2.1.2.3 *Flare Line(s)* and Section 2.1.2.4 (d) *Degasser Vent Line* of draft Guide 36. Section 1.5 *Supervision* of ID 92-1 has been modified and incorporated in Section 9.1 *Wellsite Supervision* of draft Guide 36. Section 1.6 *Specific High Hazard Area of Southeastern Alberta* has been modified and incorporated into Section 14 *High Hazard Area and Surface Casing Reductions* of draft Guide 36. ID 92-1 will be rescinded.
Interim Directive ID 89-02 – *Blowout Prevention and Drilling Practices For Core Holes and Oil Sands Evaluation Wells in Surface Mineable Areas*	The requirements of ID 89-02 (in its entirety) have been modified and incorporated in Section 20 *Oil Sands Core Holes and Evaluation Wells* of the draft Guide 36. ID 89-02 will be rescinded.
Interim Directive ID 94-3 – *Underbalanced Drilling*	The requirements of ID 94-3 are currently under review by the EUB's Well Operations Group. Although the draft Guide 36 does not deal specifically with the requirements set out in ID 94-3, certain proposed changes in the draft Guide 36 will affect underbalanced operations with regard to procedures and equipment requirements, specifically; Section 9 *Wellsite Supervision and Certification* of the draft Guide 36, Section 19 *Underbalanced Drilling* of the draft Guide 36, Section 21 *Drilling With a Service Rig and Servicing With a Drilling Rig* of the draft Guide 36 and, Section 22 *Coiled Tubing* of the draft Guide 36.

Interim Directive ID 97-6 - *Sour Well Licensing and Drilling Requirements*	Certain requirements of ID 97-6 have been modified and incorporated into the draft Guide 36, specifically; Section 4.2 (1) *Well Design* of ID 97-6 has been incorporated in Section 15.4.2 Intermediate Casing of the draft Guide 36. Section 4.3.1 (1) *BOP Stack* of ID 97-6 has been modified and incorporated in Figure 5 *BOP Stack Configurations Critical Sour Wells* (Section 15) and Section 15.4.4 *Shear Blind Rams* of the draft Guide 36. Section 4.3.1 (3) *BOP Stack* of ID 97-6 has been incorporated in Section 1.1.1 *Metallic Material For Sour Service* of the draft Guide 36. Section 4.3.1 (4) *BOP Stack* of ID 97-6 has been incorporated in Section 5.3.3 *Master Hydraulic Control Manifold Location* of the draft Guide 36. Section 4.3.1 (5) *BOP Stack* of ID 97-6 has been modified and incorporated in Section 5.1 *Accumulator System* of the draft Guide 36. Section 4.3.1 (6 and 7) *BOP Stack* of ID 97-6 has been incorporated in Section 1.2 *Casing Bowls* of the draft Guide 36. Section 4.3.1 (8) *BOP Stack* of ID 97-6 has been incorporated in Section 1.3 *Drill-Through Components* of the draft Guide 36. Section 4.3.2 (1 through 4 inclusive) *BOP manifold* of ID 97-6 has been incorporated in Section 2 *Bleed-Off and Kill Systems* and Figure 6 *Choke Manifold – Critical Sour Well* (Section 15) of the draft Guide 36. Section 4.3.2 (5) *BOP manifold* of ID 97-6 has been modified and incorporated in Section 4 *Winterizing* of the draft Guide 36. Section 4.3.3 (1 through 5 inclusive) *Mud-Gas Separators* of ID 97-6 has been modified and incorporated Section 2 *Bleed-Off and Kill Systems* of the draft Guide 36. Section 4.3.4 (4 and 5) *Drill Pipe* of ID 97-6 has been incorporated in Section 15.4.5 *Drill Pipe* of the draft Guide 36. Section 4.3.5 (1 and 2) *Drill String Valves* of ID 97-6 has been modified and incorporated in Section 1.4 *Stabbing Valve and Inside BOP* and Section 1.5 *Lower Kelly Cock Valve* of the draft Guide 36. Section 4.3.6 (1, 3 and 4) *Monitoring Equipment* of ID 97-6 has been modified and incorporated in Section 15.4.7 *H_2S Monitoring* of the draft Guide 36. Section 4.3.6 (2) *Monitoring Equipment* of ID 97-6 has been modified and incorporated in Section 15.4.8 *Sulfide Monitoring* of the draft Guide 36. Section 4.3.6 (5) *Monitoring Equipment* of ID 97-6 has been modified and incorporated in Section 8.2.2 *Automated (Electronic) Mud Tank Fluid Volume Monitoring System* of the draft Guide 36. Section 4.3.6 (6 and 7) *Monitoring Equipment* of ID 97-6 has been incorporated in Section 15.4.6 *Indicators and Recording Devices* of the draft Guide 36.

	Section 4.3.6 (8 and 9) *Monitoring Equipment* of ID 97-6 has been incorporated in Section 8.3.3 *Critical Sour Wells* of the draft Guide 36. Section 4.4.1 (1 through 4 inclusive) *Tripping* of ID 97-6 has been modified and incorporated in Section 10.3 *Tripping* of the draft Guide 36. Section 4.4.2 (1 and 3) *Testing and Coring* of ID 97-6 has been incorporated in Section 15.4.9 *Testing and Coring* of the draft Guide 36. Section 4.4.2 (2) *Testing and Coring* of ID 97-6 has been modified and incorporated in Section 16.5 *Directional Surveys – Critical Sour Wells* of the draft Guide 36. 4.4.3 *Underbalanced Drilling* of ID 97-6 has been incorporated in Section 15.4.10 *Underbalanced Drilling* of the draft Guide 36. 4.5.1 (1 and 2) *Supervision* of ID 97-6 has been modified and incorporated in Section 9.1 *Well-site Supervision*, Section 9.2.2 *Second-Line Supervisor's Well Control Certificate* and Section 15.4.11 *Personnel* of the draft Guide 36. 4.5.2 (1) *Rig Crew* of ID 97-6 has been modified and incorporated in Section 9.2.1 *First-Line Supervisor's Certificate* and Section 9.2.2 *Second-Line Supervisor's Well Control Certificate* of the draft Guide 36. 4.5.2 (2 and 4) *Rig Crew* of ID 97-6 has been incorporated in Section 15.4.11 *Personnel* of the draft Guide 36. 4.5.2 (3) *Rig Crew* of ID 97-6 has been incorporated in Section 8 *Mud Tanks and Fluid Volume Monitoring Systems* of the draft Guide 36. 4.5.3 (1 and 2) *Service Personnel* of ID 97-6 has been incorporated in Section 15.4.11 *Personnel* of the draft Guide 36. 4.5.4 *Safety Specialists* and Equipment of ID 97-6 has been incorporated in Section 15.4.11 *Personnel* of the draft Guide 36. 4.6 *Inspection* (1 and 2) of ID 97-6 has been incorporated in Section 17.2 *Detailed Inspections* of the draft Guide 36.
Interim Directive ID 91-3 – *Heavy Oil/Oil Sands Operations*	All references to Class 1A BOP systems in Section 1, *Drilling Blowout Prevention Requirements* of ID 91-3, now refer to the Class 1 Blowout Preventer Systems as illustrated in Appendix 3 of the draft Guide 36. Section 1.2.1 (3) *Class 1A BOP System of ID 91-3* has been modified and incorporated in Section 5.4.2 and Section 6.1.1 of the draft Guide 36.
Informational Letter IL 88-11 – *Shop Servicing and Testing of Blowout Preventers and Flexible Bleed-Off and Kill-Line Hoses.*	The requirements of IL 88-11 (in its entirety) have been modified and incorporated in Section 1.7 *Shop Servicing and Testing of BOPs, BOP Spools and Flexible Bleed-off and Kill Line Hoses* of the draft Guide 36. IL 88-11 will be rescinded.
Informational Letter IL 88-17 – *Ignition Equipment for Drilling Critical Sour Wells*	The requirements of IL 88-17 (in its entirety) have been modified and incorporated in Section 15.4.12 *Ignition Criteria* of the draft Guide 36. IL 88-17 will be rescinded.

Overview

Purpose of the Guide

Guide 36: Drilling Rig Requirements and Inspection Guide details the Alberta Energy and Utilities Board (EUB) minimum equipment and procedure requirements that the licensee must follow when drilling wells in the Province of Alberta. In addition, the guide provides a reference for EUB drilling rig inspection staff to assist in completing the EUB Drilling and Servicing Inspection Report.

What's New in This Guide

The revised version of *Guide 36* extensively updates, expands, and completely replaces the June 1995 edition of *Guide 36*. This guide details satisfactory and minor/major/serious unsatisfactory inspection results, as well as consequences for noncompliance in accordance with the EUB's enforcement process.

What This Guide Contains

This guide contains 23 sections that detail minimum equipment and procedure requirements for drilling wells in the Province of Alberta. In addition, there are 17 appendices of supplemental information.

The guide also describes the role of the EUB Field Centre inspectors and includes the EUB Drilling and Servicing Inspection Report that EUB field inspectors complete for each site inspected (see pages 5 to 12).

Alberta Municipal Affairs, Safety Services Branch

Both the EUB and Alberta Municipal Affairs, Safety Services Branch (SSB) (formerly the Electrical Protection Branch) have responsibilities regarding electrical systems at drilling rigs.

An agreement between the EUB and SSB (see Appendix 14) describes and formalizes the expectations of the EUB and the SSB with regard to electrical systems at rigs.

Non-EUB Users

While every effort has been made to ensure the accuracy and reliability of the technical data presented in this manual, the EUB does not guarantee the data and hereby disclaims responsibility for loss or damage resulting from its use. It is the responsibility of the user to verify the data provided.

Waivers

Licensees who wish to be exempt from any requirement of this guide must submit a written request for the waiver involved to EUB Well Operations in Calgary. Waivers resulting in major modifications to blowout preventer (BOP) components or procedures will not be granted by the EUB Field Centres.

EUB Field Centre staff may grant spacing exemptions verbally if the operator contacts the appropriate Field Centre prior to commencing operations.

EUB Responsibilities

The EUB's responsibilities with respect to drilling are

- according to the Oil and Gas Conservation Act, Part 1, Section 4(b)(d)(f):

  …to secure the observance of safe and efficient practices in the locating, spacing, drilling, equipping, completing, reworking, testing, operating, and abandonment of wells and in operations for the production of oil and gas…

  …to control pollution above, at or below the surface in the drilling of wells and in operations for the production of oil and gas and in other operations over which the Board has jurisdiction.

Conducting a Drilling Rig Inspection

Introduction

A drilling rig inspection is normally conducted after the licensee has set surface casing and drilled out the shoe or after the commencement of drilling operations with a diverter system.

The EUB's inspection selection criteria are based primarily on past operator performance, sensitivity of the area, and potential impact of the drilling operation.

Deficiencies will not be recorded prior to drilling out the surface casing shoe or prior to the commencement of drilling operations with a diverter system.

EUB Inspector's Role

The EUB inspector's role is to ensure compliance with EUB requirements.

The EUB inspector must be receptive to concerns and questions regarding the Oil and Gas Conservation Regulations and/or EUB requirements and provide further clarification and information as requested.

EUB Inspector's Focus

Whenever possible, the inspection should be conducted without prior notice being given to the licensee and/or contractor representatives.

Upon arrival at the site, the EUB inspector should contact the licensee and contractor representatives. If they are unavailable, the inspector should locate the driller. The inspector should take time to get acquainted and explain the purpose of the visit.

The inspector should thoroughly evaluate equipment, procedures, and operating policies on site, including

- well control information and procedures,
- stick diagram (offset well data, expected hydrogen sulphide [H_2S] content, formation tops and pressures, and the minimum mud weight required to control the expected formation pressures, expressed in kilograms per cubic metre [kg/m^3]), and
- crew training, kick prevention, detection, and well control.

There may be situations where the licensee and/or contractor representatives request that the BOPs not be checked because of the current drilling operation. The inspector must use discretion in deciding to proceed with the inspection. An abbreviated inspection may still be conducted.

The inspector should consult with the Field Centre Team Leader if there is concern about conducting the inspection.

EUB Inspector's Safety

Each inspector must

- discuss with the licensee and/or contractor representatives to determine if hole conditions are safe to conduct an inspection,
- comply with all safety procedures in EUB *Internal Guide 8: Safety Manual,* specifically the Field Inspection Practices and Procedures Section, and
- comply with licensee's and contractor's specific safety policies.

Industry's Role

The EUB expects the licensee and contractor representatives to understand, respect, meet, and/or exceed the EUB's drilling regulations and requirements. This is achieved in part by

- internal inspections and compliance programs,
- awareness of the licensee's EUB inspection record and taking appropriate action where necessary,
- ongoing training of well-site personnel for safety, well control, and equipment,
- informing well-site personnel of potential hole problems, sensitive environmental concerns, and public issues, in order to ensure that appropriate action plans are implemented, and
- cooperation with the EUB, government, and public by open communication to address areas of mutual concern.

EUB Enforcement Process

The EUB has adopted an enforcement process to address noncompliance issues with a series of escalating enforcement consequences. The definitions of what constitutes a minor, major, or serious unsatisfactory inspection and examples are set out in Operational Deficiencies (Appendix 1).

The EUB reserves the right to escalate noncompliance issues to any level should conditions warrant.

Completing the Drilling and Servicing Inspection Report

EUB Alberta Energy and Utilities Board

Drilling and Servicing Inspection Report

Guide 36 and *Guide 37*

☐ Inspection date or
☐ Investigation complete date

Y	M	D

A. GENERAL INFORMATION

Licensee

Licensee code

Well Identifier

	LE	LSD	SEC	TWP	RGE	W	M	O	E
1						W		O	

Contractor

Contractor code

Rig number

Licence number

Code

Field centre

Rig type	Inspection type	Current depth (m)	Projected depth (m)	Casing setting depth (m)			Well class	Current operation
				Surface	Intermediate	Production		

B. MECHANICAL TESTS

Accumulator			Recharge pump		BOP controls		BOP function test	Time to operate	
Make			Time	min	No. on floor				
No. of bottles		Capacity (L)	N_2 bottles		Type		HCR		S
Design pressure		kPa	Number		No. of remote		Annular		S
Precharge pressure		kPa	Capacity	(L)	Type		Ram		S
Pressure before		kPa	Average pressure	kPa	Distance	m	Ram		S
Pressure after		kPa			Hand wheels		Ram		S

C. INSPECTION RESULTS (Satisfactory "X", Minor "U", Major "M", Serious "S")

1. ☐ Blowout Prevention System
2. ☐ Bleed-off and Kill System
3. ☐ Flexible Hoses
4. ☐ Winterizing
5. ☐ BOP Control Systems
6. ☐ Pressure Testing
7. ☐ Engines
8. ☐ Mud Tanks and Fluid Volume Monitoring System
9. ☐ Well-Site Supervision and Certification
10. ☐ Well Control, Crew Training, and Tripping Requirements
11. ☐ Electric and Flame-Type Equipment
12. ☐ Casing Inspection
13. ☐ Drillstem/Well Testing
14. ☐ High-Hazard Area and Surface Casing Reductions
15. ☐ Sour and Critical Sour Wells
16. ☐ Well-Site Records and Reporting
17. ☐ Licensee and Contractor Inspections
18. ☐ Well-Site Fluids and Environment
19. ☐ Underbalanced Drilling
20. ☐ Core Holes and Oil Sands

E. ENFORCEMENT ACTION

Satisfactory inspection ☐

Unsatisfactory inspection ☐

Consequences for future noncompliance

Level ______________________

(see reverse)

Letter required? (circle one) **YES** **NO**

D. COMMENTS

F. SIGNATURES AND ON-SITE DISCUSSIONS

Operator representative (print)	Licensee signature	Rig down time
Contractor representative (print)	Contractor signature	:
EUB inspector name (print)	Telephone number ( )	Fax number ( )

Alberta Energy and Utilities Board 640-5 Avenue SW Calgary, Alberta Canada T2P 3G4

F-39-2003-04

ENFORCEMENT ACTIONS REQUIRED

OPERATORS must ensure that the necessary work detailed under Comments (D) on reverse is completed and confirmed by the deadline date. Contact the local EUB Field Centre or fax a copy of this inspection with your comments to the Field Centre. Be sure to include your name and phone number. Check all of your other facilities in the area for the same deficiencies.

Minor Level 1

- Local company representative instructed to take corrective action.
- Company must confirm corrective action **(verbally or in writing)** to EUB Field Centre.
- Maximum time to take corrective action: = 30 days.

Minor Level 2

- Local company representative instructed to take corrective action.
- Senior company representative with provincial authority must provide in writing to the EUB Field Centre why EUB directive not followed and provide an acceptable action plan for following EUB directives in the future.
- Maximum time to take corrective action: = 15 days.

Minor Level 3

- Full or partial suspension of operations.
- Local company representative instructed to take corrective action.
- Senior company representative with provincial authority must provide in writing to the EUB Field Centre why EUB directive not followed and provide an acceptable action plan for following EUB directives in the future.
- Suspension remains in effect until noncompliance is remedied, a documented meeting/discussion is held with senior company representative with provincial authority, and the EUB removes suspension **(in writing).**
- Noncompliance added to Corporate Data Information System.

Minor Level 4

- Immediate suspension (full or partial).
- Suspension remains in effect until documented meeting with senior company representative with provincial authority (VP/Pres).
- Senior company representative with provincial authority confirms compliance at this and all similar rigs in this inspection category.
- Senior company representative with provincial authority must provide a written acceptable action plan, including examination of cause and future prevention plans at this and all similar rigs.
- And/or EUB Corporate Compliance issues closure order, miscellaneous order, and/or refer status for future applications.

Major Level 2

- Temporary suspension of operations (full or partial) when safe to do so may occur to correct deficiency or alleviate impact or potential impact.
- Local company representative instructed to take corrective action.
- Senior company representative with provincial authority must provide in writing to the EUB Field Centre why EUB directive not followed and provide an acceptable action plan for following EUB directives in the future.
- Company has 30 days to correct operations in same inspection category on a provincial basis.

Major Level 3

- Same as Minor Level 3
- Company has 15 days to correct operations in same inspection category on a provincial basis.

Major Level 4

- Same as Minor Level 4.

Serious Level 3

- Full or partial suspension of operations when safe to do so.
- Company instructed to take corrective action.
- Company must explain why event occurred, provide written acceptable action plan, and ensure that issue/event does not recur.
- Company must confirm that this and all similar rigs are in compliance.
- Operations remain suspended until noncompliance remedied, EUB accepts action plan, and written approval is received from EUB to resume operations.
- Noncompliance added to Corporate Data Information System.

Serious Level 4

- Same as Major Level 4.

Note: The above enforcement action items are a summary from the EUB Field Surveillance Enforcement Ladders in *IL 99-4*. Please refer to this IL or contact the local EUB Field Centre for further details. The EUB reserves the right to escalate noncompliance issue(s) to any level should conditions warrant.

Completing the Drilling and Servicing Inspection Report

A General Information

If more than one inspection report page is required to provide comments, be sure to

- number each page on the top right-hand corner (Page 1, Page 2, etc.);
- complete Section A on all pages;
- leave the remainder of the form (other than the Comments section) blank after page 1; and
- have all pages signed.

Licensee	Enter the full name of the licensee of the well.
Licensee Code	Leave blank.
Well Identifier	Enter the 13-character unique well identifier.
Inspection Date or Investigation Complete Date	Circle the appropriate type to indicate whether this is an inspection or an investigation. Enter the date the inspection was conducted, or enter the date the investigation was completed (for all investigations conducted on drilling and servicing operations where a physical inspection of the rig was not conducted).
Contractor	Enter the full name of the contractor.
Contractor Code	Leave blank.
Rig Number	Enter the rig number.
Licence Number	Enter the well licence number.
Field Centre	Enter the 2-digit code and the full name of the Field Centre in whose area the inspection was conducted: 03 Wainwright 04 Midnapore 05 Bonnyville 06 Drayton Valley 07 St. Albert 08 Medicine Hat 09 Red Deer 10 Grande Prairie
Rig Type	Enter **"D"** for drilling operation.
Inspection Type	Enter **"C"** for complete when a pressure test of the BOPs has been witnessed in whole or in part. Enter **"P"** for partial for all other inspections if a pressure test has not been witnessed.
Current Depth	Enter the current depth in metres (m).
Projected Depth	Enter the licensed depth (m).

Casing Setting Depth	Enter depth of all casing set (m).
Well Class	Enter the well class.
Current Operation	Enter the current operation. If in doubt, ask the on-site licensee and/or contractor representatives.

B Mechanical Tests

Accumulator	Record the • accumulator make • number of bottles • capacity in litres (L) • design pressure in kilopascals (kPa) • precharge pressure (kPa) • pressures before and after the BOP mechanical test (kPa)
Recharge Pump	Record the time required to recharge the accumulator system in minutes (min).
N_2 Bottles	Record the • number of nitrogen (N_2) bottles • capacity (L) • combined average pressure (kPa)
BOP Controls	Record the • number of floor BOP controls • type of floor BOP controls (air, hydraulic, electric, etc.) • number of remote BOP controls • type of remote BOP controls (air, hydraulic, electric etc.) • distance of the remote controls from the well (m) • hand wheels—indicate whether locking hand wheels for ram-type BOPs are available by entering "Y" or "N"; if the rams have automatic locking devices (posi-lock), enter N/A
BOP Function Test	Record the type (e.g., annular, pipe ram, hydraulically operated valve [HCR]) of BOP function tested.
Time to Operate	Enter the time, in seconds (s), to operate each BOP component.

C Inspection Results

The expectation is to inspect as many items as possible. Even if only one rig item is examined, an inspection report must be completed.

No box on the inspection report should be left blank. Since the inspection report includes both drilling and servicing operations, not all the boxes will be applicable. If boxes are not applicable to the type of operation being inspected, put a horizontal line through the box.

See Appendix 1 for operational deficiencies and *Informational Letter (IL) 99-4: EUB Field Surveillance Enforcement Process and Ladder* for details of major, minor, and serious unsatisfactory items as outlined in the EUB Field Surveillance enforcement ladders.

Each item under Inspection Results on the inspection report sheet is discussed in the next sections, with a complete description of the components to be inspected.

After inspecting all relevant components, enter the appropriate inspection result (X, U, M, or S).

- Mark "X" if satisfactory.
- Mark "U" if minor unsatisfactory.
- Mark "M" if major unsatisfactory.
- Mark "S" if serious unsatisfactory.

D Comments

Clearly define each inspection item marked unsatisfactory (U, M, or S) on the inspection form. Indicate the type of remedial action required to correct the deficiency and the deadline date for compliance.

If an unsatisfactory item is corrected during the inspection, make a note of it in this section.

E Enforcement Action

Enter "X" if the inspection is satisfactory.

Enter the appropriate code (U, M, or S) if the inspection is unsatisfactory.

Indicate the appropriate noncompliance level. See *IL 99-4*.

Indicate the consequences for future noncompliance. See *IL 99-4*.

Circle "Yes" or "No" to answer whether a letter to the operator is required.

F Signatures and On-Site Discussions

The EUB inspector must review this report with the licensee representative on site and discuss any enforcement and/or remedial actions required.

Licensee Representative; Contractor Representative	The licensee and contractor representatives must print and sign their names clearly in the space provided on the completed inspection report. If the report is more than one page, all pages must be signed.
EUB Inspector	Enter the inspector's name, telephone number, and fax number, including area codes.
Rig Down Time	Enter the total time (to the nearest quarter hour) that operations were interrupted to carry out the rig inspection and/or subsequent remedial action.
Submission of Inspection Report (3 copies)	Give the licensee's representative a copy of the completed inspection report (yellow copy). File the completed drilling inspection report (pink copy) with your Field Centre for database entry. Send the white (original) copy to Calgary head office for filing.

Inspection Items Detailed

Sections 1-23 provide details on the items to be inspected as listed on the Drilling and Servicing Inspection Report.

1 Blowout Prevention System

For purposes of the drilling blowout prevention requirements set out in this guide, wells are classified as set out below:

- Class I: A well in which no surface casing is set
- Class II: A well in which the true vertical depth is less than or equal to 750 m
- Class III: A well in which the true vertical depth is greater than 750 m and less than or equal to 1800 m
- Class IV: A well in which the true vertical depth is greater than 1800 m and less than or equal to 3600 m
- Class V: A well in which the true vertical depth is greater than 3600 m and less than or equal to 6000 m
- Class VI: A well in which the true vertical depth is greater than 6000 m

For more detailed information, see Appendix 3. (For coiled tubing unit requirements, see Section 22.)

1.1 Blowout Preventer (BOP) Equipment

For all well classes, BOP equipment must be installed and maintained that is

- adequate to shut off a flow at the wellhead, whether or not any type of tool or equipment is being used in the well;
- in accordance with the well classification and specifications as outlined in Appendix 3 and in Section 22 for coiled tubing units (CTUs);
- adequately supported and secured (to substructure) to prevent stresses on all connections;
- in accordance with any other applicable EUB requirements; and
- in accordance with Section 15 for critical sour wells.

1.1.1 Metallic Material for Sour Service

For critical sour wells, all pressure-containing components within the BOP, bleed-off, and kill systems must meet *National Association of Corrosion Engineers (NACE)*

MR0175: Standard Material Requirements—Sulphide Stress Cracking Resistant Metallic Material for Oilfield Equipment (latest edition).

For all noncritical sour wells, the EUB recommends that the licensee evaluate the potential H_2S content and wellbore pressures that the surface pressure controlling equipment (BOP, bleed-off, and kill systems) may be exposed to. If a sour environment, as defined by NACE exists, the licensee should consider deployment of surface pressure controlling equipment constructed of alloys that meet NACE standards (see Appendix 4; also see *NACE TM 0187-87: Standard Method for Evaluating Elastomeric Materials in Sour Gas Environments*).

1.1.2 Pipe Rams

For well classes II to VI, the pipe rams must be the correct size for the drill pipe (or coiled tubing string) that is in use. This may require the use of variable bore rams.

If any pipe rams are changed out during the drilling operation, they must be pressure tested.

1.1.3 Casing Rams

If intermediate/production casing or a liner will be run into the well, the pipe rams do not have to be replaced with casing rams. If pipe rams are replaced with casing rams, they must be pressure tested.

1.1.4 Ram Locking Devices (Hand Wheels)

Ram-type BOPs that are not equipped with automatic ram locking devices must have a ram locking device(s) (e.g., hand wheel(s), ratchet and socket) either installed or readily accessible for installation.

1.1.5 Double Drilling/Studding

The double drilling/studding of BOP equipment (e.g., BOP body, BOP flanges, adapter flanges, or spools) is acceptable. However, the following applies:

- Double studding of the BOP body to accept two sizes of API flanges (for equipment that may have a lower pressure rating) does not result in the derating of the preventer.
- Any modification to flanged BOP equipment (e.g., double drilling or studding) to accommodate connections to other API equipment that may have a lower pressure rating results in a derating of the flange to the lower working pressure.

If a modified flange is to be used in an application requiring its original pressure rating, the licensee must provide documentation from either the original equipment manufacturer (OEM) or a professional engineer (P.Eng.) that the flange is certified for the higher-pressure rating. Equipment identification must be established with a certification document.

1.1.6 Flange- and Clamp-Type Connections

Where flange connections are required in the BOP system, they must meet the following requirements:

- They must be designed in accordance with American Petroleum Institute (API) standards.
- All required studs, bolts, and nuts on any flange- or clamp-type connections must be installed and properly made up.
- Whenever a connection is loosened or taken apart after drill-out, a pressure test must be conducted on the connection. (It may be necessary to set a plug or packer in the surface casing to conduct the pressure test.)

Clamp-type connectors that serve the same function as a high-pressure flanged assembly may be used in the BOP system to replace a flanged connection.

1.1.7 Redundant BOP Equipment

For all well classes whenever redundant BOP equipment (e.g., additional pipe rams, lower kelly cock, HCR) is in use, the equipment must be

- functional at all times (unless the equipment is locked out);
- included in all pressure testing; and
- included in accumulator and backup nitrogen system volume calculations.

1.2 Casing Bowls

For class I wells, sliplock type, threaded, or weld-on casing bowls may be used.

For well classes II to VI and critical sour wells, only threaded or weld-on casing bowls are permitted.

1.2.1 Sliplock

Sliplock type casing bowls must be installed and maintained in accordance with the manufacturer's specifications.

When a sliplock type casing bowl is used, the licensee must provide documentation from either the OEM or a P.Eng. that the casing bowl is certified for the application in use.

1.2.2 Threaded

Threaded casing bowls must be properly installed with regard to make-up procedures, torque, and the use of thread compounds as set out in the current editions of the following documents:

- *API Spec 6A: Specification for Wellhead and Christmas Tree Equipment*

- *API RP 5C1: Care and Use of Casing and Tubing*

- *API Bul 5A2: Bulletin on Thread Compounds*

1.2.3 Welded

Weld-on casing bowls must be welded in accordance with acceptable welding procedures as set out in the current editions of the following documents:

- *API Spec 6A: Specification for Wellhead and Christmas Tree Equipment* (13th edition)

- *American Society of Mechanical Engineers (ASME): Boiler and Pressure Vessel Code,* Section IX

- *Canadian Standards Association (CSA) Z184: Standards for Gas Pipeline Systems*

- *NACE MR0175*

- *Industry Recommended Practice (IRP) Volume 1: Drilling Critical Sour Wells,* which also contains additional details regarding welding procedures

1.2.4 Casing Bowl Flange, Outlet(s), and Valve(s)

The casing bowl must have

- a casing flange that is an integral part of the bowl,

- at least one threaded, flanged, or studded side outlet and valve on well classes I, II, III, and IV, and

- two flanged or studded side outlets and valves on well classes V and VI.

1.2.5 Pressure Rating

The casing bowl and valve(s) installed must meet the minimum pressure rating requirements for the class of well being drilled (see Appendix 3). Casing bowl specifications must be available at the rig.

If the casing bowl and/or valves do not meet the minimum pressure rating requirements for the well class being drilled, the bowl and/or valves must be changed out. Drilling conditions must be stable and the well must be secured (e.g., use temporary bridge plug) prior to replacing the bowl and/or valves.

After the bowl or valve(s) has been replaced, a pressure test is required.

1.3 Drill-Through Components

For well classes III to VI and critical sour wells, drill-through component(s) positioned between the top flange of the uppermost BOP and the rotary table (or slip table for top drives) must be removable with pipe or tools in the wellbore (i.e., flow tees, automatic pipe wiping devices, rotary drilling heads, etc., must be either of two-piece construction or sized so that it can pulled through the floor with the table bushings removed).

The above does not apply to CTUs.

1.4 Stabbing Valve and Inside BOP

For all well classes, the drilling rig must be equipped with a stabbing valve and an inside BOP. The use of a float in the drill string does not eliminate the need for an inside BOP.

The stabbing valve and inside BOP must meet the following requirements:

- For well classes V and VI and for critical sour wells, the stabbing valve must be certified by the OEM or a P.Eng. as being capable of opening with 7000 kilopascals (kPa) pressure below the valve.
- The stabbing valve must be full opening and equipped with a valve operating wrench.
- The stabbing valve must be stored in the open position.
- The inside BOP must be capable of stopping back flow up the drill string.
- The stabbing valve and inside BOP, as well as associated tools, must be operable and readily accessible on the rig floor or in the doghouse.
- The drilling rig must be equipped with the necessary cross-over subs to enable the make-up of the stabbing valve and inside BOP with the drill pipe, drill collars, or any other tubulars in the well.
- The stabbing valve and inside BOP must be equipped with handles if more than one person is required to carry the valve(s). A full open hanger cap assembly may be used in place of handles. All handles and hanger caps must be removable to allow the valve(s) to be stripped into the well.
- The stabbing valve and inside BOP must be capable of being stripped into the wellbore.
- For critical sour wells, the stabbing valve and the inside BOP must be constructed of materials that meet the *NACE MR0175* standards (latest edition).

For coiled tubing units where the bottomhole assembly can be fully lubricated into or out of the well (no staged deployment), a stabbing valve or inside BOP is not required. Where the bottomhole assembly must be staged, a stabbing valve is required. There is no requirement for an inside BOP.

1.5 Lower Kelly Cock Valve

For well classes V and VI and critical sour wells, the kelly must be equipped with a lower kelly cock valve that meets the following requirements:

- The lower kelly cock valve must be certified by the OEM or a P.Eng. as being capable of opening with 7000 kPa pressure below the valve.

- The lower kelly cock valve must be installed at all times.

- The lower kelly cock valve must be full opening and equipped with a valve operating wrench.

- For critical sour wells, the lower kelly cock valve must be constructed of materials that meet the *NACE MR0175* standards (latest edition).

1.6 Stripping Operations

For all well classes during normal drilling operations, the following requirements must be met regarding stripping tubulars through the BOPs:

- Stripping of any connection, tool joint, or coiled tubing is not permitted through the sealing element of an annular preventer that is part of the required BOP equipment (see Appendix 3).

- Stripping of any length of pipe/coiled tubing is not permitted through a pipe ram preventer that is part of the required BOP equipment (see Appendix 3).

During well control situations, stripping through the annular preventer is permitted.

1.7 Shop Servicing and Testing of BOPs, BOP Spools, and Flexible Bleed-off and Kill-line Hoses

All BOPs, BOP spools, and flexible bleed-off and kill-line hoses used during the drilling operation must be shop serviced (dismantled and repaired) and pressure tested at least once every three years according to the manufacturer's specifications or specifications prepared by a P.Eng. (see Appendix 5).

2 Bleed-Off and Kill Systems

2.1 Bleed-off System

The blowout prevention system must include a bleed-off system for the purpose of bleeding off well pressure.

2.1.1 Class I Wells

For class I wells, the bleed-off system consists of a diverter line, which is the line from the BOP to the flare pit or flare tank, and includes the HCR.

2.1.1.1 Diverter Line

The diverter line must meet the following requirements:

- The diverter line must have a working pressure at least equal to that of the required BOP system (see Appendix 3).
- The diverter line must have a minimum nominal diameter of 152.4 millimetres (mm) throughout.
- The diverter line must have an HCR installed on the drilling spool outlet.
- The HCR must be connected directly to the drilling spool (no fluid turns or pipe extensions) (see Appendix 3).
- The diverter line downstream of the HCR may contain directional changes provided that they are made with right-angle (90°) connections constructed of tees and crosses blocked on fluid turns.
- Directional changes in the diverter line may also be made using flexible hose provided that the hose meets the requirements set out in Section 3.1: Bleed-off, Kill, or Diverter Line(s).
- The diverter line connections must be flanged, hammer union, or threaded.
- The diverter line must be properly made up and connected at all times.
- The end of the diverter line must terminate at least 50 m from the well in a flare pit or flare tank. For exceptions to this requirement, see *ID 91-3: Heavy Oil/Oil Sands Operations* and *Guide 8: Surface Casing Depth Minimum Requirements*, Section 1.1.
- The diverter line must be adequately secured at 10 m intervals and the end of the line must be secured as close as possible to the flare pit. Stakes or weights must be used, as dictated by the soil conditions. Stakes used in sandy or loose soil conditions are unacceptable.
- Fluids turns such as elbows, tees, etc., are not permitted at the end of the diverter line to direct wellbore effluent into a flare pit.

- The diverter line must be self-draining or some means be incorporated to ensure that fluid can be drained from the line during winter operations. Precautions must be taken to minimize environmental impact from spillage.

- The diverter line must be laid in a straight line; however, a slight curvature of the line is acceptable.

- Auxiliary diverter line(s) must meet the same requirements as above.

- Prior to assembly, all connections between the BOP and the end of the diverter line must be visually inspected. After assembly of the connections, an inspection must be conducted to ensure proper make-up. The results of the inspections must be recorded in the drilling log book.

2.1.2 Well Classes II-VI and Critical Sour Wells

For well classes II-VI and critical sour wells, the bleed-off system includes bleed-off line(s), choke manifold, flare line(s), mud gas separator(s) (degasser), degasser inlet line(s), and degasser vent line(s).

2.1.2.1 Bleed-off Line(s)

The bleed-off line(s) consists of the line from the BOP stack to the manifold and includes both the hydraulically operated and manual valves.

The bleed-off line(s) must meet the following requirements:

- The bleed off line(s) installed must meet the minimum pressure rating requirements for the class of well being drilled (see Appendix 3).

- For well classes V and VI and critical sour wells, the bleed-off line piping must provide complete redundancy from the BOP stack through to the manifold, so that a separate bleed-off line from each working spool connects to a separate manifold wing (see Appendix 3 and Section 15: Sour and Critical Sour Wells).

- The bleed-off line(s) must have a minimum nominal diameter of 76.2 mm throughout.

- The bleed-off line(s) connections must be flanged or clamp-type connections and designed in accordance with API standards.

- All required studs, bolts, and nuts on any flange- or clamp-type connections must be installed and properly made up. Whenever a connection is loosened or taken apart after drill-out, a pressure test must be conducted on the connection. (It may be necessary to set a plug or packer in the surface casing to conduct the pressure test.)

- The bleed-off line(s) off the drilling spool(s) must contain two flanged valves. On the primary bleed-off line, one of the valves must be hydraulically operated (the other valve can be a manual valve) (see Appendix 3). The position of the HCR (whether it is the innermost or outermost valve) is left to the licensee's discretion. It is recommended that the HCR be the innermost valve.

- During normal drilling operations, the HCR(s) on the primary and secondary (if in use) bleed-off line must be in the closed position and the manual valve(s) must be in the open position.
- During normal drilling operations, where a secondary bleed-off line is required or in use, only one of the manual valve(s) on the secondary bleed-off line can be in the closed position (only if no HCR is installed).
- All manual valves in the primary and secondary bleed-off lines must be operable with the valve handle(s) in place at all times.
- Piping extensions or fluid turns are not permitted between the drilling spool, HCR, or manual valve(s). Valves must be flanged together and connected directly to the drilling spool (see Appendix 3).
- The line(s) downstream of the HCR and manual valve(s) may contain directional changes, provided they are made with right-angle (90°) connections constructed of tees and crosses blocked on fluid turns.
- Directional changes in the bleed-off line(s) can also be made using flexible hose, provided the hose meets the requirements set out in Section 3.1: Bleed-off, Kill, or Diverter Line(s).
- The bleed-off line(s) must be connected to the drilling spool and choke manifold at all times.
- The bleed-off line(s) must be properly supported to prevent stresses on connecting valves and fittings.
- The bleed-off line(s) must be properly secured every 10 m (e.g., fastened to catwalk, pipe racks, or staked).
- For critical sour wells, the bleed-off lines must meet *NACE MR0175* standards (latest edition).

2.1.2.2 Choke Manifold

The choke manifold consists of high-pressure pipe, fittings, flanges, valves, pressure gauges, and hydraulically and/or manually operated adjustable chokes.

The choke manifold must meet the following minimum requirements:

- The choke manifold must meet the minimum pressure rating and conform to the minimum choke manifold design (valves, chokes, piping, etc.) for the class of well being drilled (see Appendix 3).
- For critical sour wells, the choke manifold must conform to the minimum choke manifold design (valves, chokes, piping, etc.) as outlined in Section 15, Figure 6. In addition, the remote hydraulically operated choke (on the primary manifold wing) must be a nonrubber sleeved choke.

- All chokes must be labelled to identify the fully open and the fully closed positions.
- All chokes and valves must be operable with the valve handle(s) in place at all times.
- An accurate choke manifold casing pressure gauge(s) must be installed or readily accessible for installation for reading the casing pressure at the choke manifold regardless of which choke line is in use and at the remote choke control location (if in use and/or required).
- For well classes V and VI and critical sour wells, a separate casing pressure gauge is required for each choke manifold wing.
- If only surface casing has been set, the choke manifold casing pressure gauge(s) must have readable increments of 250 kPa or less and a recommended range of 0-10500 kPa. The range of the casing pressure gauge(s) must not be less than the maximum allowable casing pressure (MACP).
- If intermediate casing is set, the choke manifold casing pressure gauge(s) must have readable increments of 500 kPa or less. The range of the casing pressure gauge must not be less than the pressure rating of the required BOP system.
- All choke manifold gauges must have isolation valves.
- For critical sour wells, the choke manifold must meet *NACE MR0175* standards (latest edition).

2.1.2.2(a) Remote Drill Pipe Pressure Gauge Assembly at Choke Control

The remote drill pipe pressure gauge assembly must meet the following requirements:

- The remote drill pipe pressure gauge assembly must have an accurate pressure gauge and other necessary equipment installed or readily accessible for installation on the standpipe (or other suitable connection) to provide the drill pipe pressure at the choke manifold and at the remote choke control location (if in use and/or required).

  The rig crew must assemble this equipment as part of the BOP drill (only if equipment is not already installed).
- The choke operator must be able to read the drill pipe pressure gauge when operating the choke from the choke manifold or at the remote choke control location (if in use and/or required).
- All remote drill pipe pressure gauges must have isolation valves.

2.1.2.3 Flare Line(s)

The flare line(s) consists of the line from the choke manifold to the flare pit or flare tank.

The flare line(s) must meet the following requirements:

- The flare line must have (as a minimum) a working pressure equal to that of the required BOP system (see Appendix 3).
- The flare line(s) must have a minimum nominal diameter of 76.2 mm throughout.
- The flare line(s) must be properly made up and connected to the manifold at all times.
- The flare line(s) may contain directional changes, provided they are made with right-angle (90°) connections constructed of tees and crosses blocked on fluid turns.
- Fluids turns are not permitted at the end of the flare line to direct wellbore effluent into a flare pit.
- Directional changes in the flare line(s) can also be made using flexible hose, provided the hose meets the requirements set out in Section 3.2: Flare and Emergency Flare Line(s).
- The flare line(s) connections must be flanged, hammer union, or threaded.
- The flare line(s) must be adequately secured at 10 m intervals, and the end of the line(s) must be secured as close as possible to the flare pit. Stakes or weights must be used as dictated by the soil conditions. Stakes used in sandy or loose soil conditions are unacceptable.
- The end of the flare line(s) must terminate at least 50 m from the well in a flare pit or flare tank.
- The flare line(s) must be either self-draining or have some means incorporated to ensure that fluid can be drained from the line(s) during winter operations. Precautions must be taken to minimize environmental impact from spillage.
- The flare line(s) should be laid in a straight line from the manifold to the flare pit/tank. However, a slight curvature of the flare line(s) is acceptable.
- Prior to assembly, all connections between the choke manifold and the end of the flare line(s) must be visually inspected. After assembly of the connections, an inspection must be conducted to ensure the flare line has been properly connected. The results of the inspections must be recorded in the drilling tour reports.
- Auxiliary flare line(s) must meet the same requirements as above.
- For well classes V and VI and critical sour wells, a minimum of two flare lines must be installed.
- For critical sour wells, the flare line must meet *NACE MR0175* standards.

2.1.2.4 Mud-Gas Separator(s)—Degasser

Degasser design must meet the technical specifications provided in the *IRP Volume 1: Industry Recommended Practices for Drilling Critical Sour Wells*, Section 1.7: Mud Gas Separators.

The minimum sizing requirements for mud-gas separators, inlet lines and vent lines are outlined in Table 1: Vessel Sizing and Vent Line Specifications. Note that any variation from Table 1 of minimum vent line diameter size must be determined by calculation.

Table 1. Vessel sizing and vent line specifications

Well class	Well depth rating (m)	Minimum vessel diameter* (mm)	Minimum vessel inlet (mm)	Minimum vent line diameter (mm)**		
				With 0.75 m fluid head	With 1 m fluid head	With 2 m fluid head
II	0-750	355.6	50.8	101.6	101.6	101.6
III	750-1250	406.4	50.8	101.6	101.6	101.6
	1250-1800	609.6	76.2	N/A	152.4	127.6
IV	1800-2700	660.4	76.2	N/A	172.9	152.4
	2700-3600	762.0	76.2	N/A	203.2	152.4
V	3600-6000	914.4	101.6	N/A	254.0	203.2
VII	6000+	914.4	101.6	N/A	254.0	203.2

* Vessel diameter determined using a vapour load constant (k) of 0.11 m/s.

** All sizes are inside diameter (ID)

2.1.2.4(a) Primary Degasser

For well classes II-VI and critical sour wells, a primary degasser must be installed that meets the following requirements:

- The degasser must meet the minimum sizing requirements for the well depth (see Table 1).
- The degasser must be an atmospheric open-bottom degasser.
- The degasser must be connected to a separate vent line.
- The degasser must be ready for service, fully connected, and immersed in drilling fluid to the minimum fluid level requirement for the well class (unless equipment, piping, connections, and procedures are in place to allow immediate filling of the tank). For minimum fluid level requirements, see Table 1.
- Degassers must not be located in the trip tank compartment.
- Degassers for critical sour wells must meet *NACE MR0175* standards (latest edition).

2.1.2.4(b) Secondary Degasser (Critical Sour Wells)

For critical sour wells a secondary degasser is required unless the following minimum conditions can be met:

- The maximum potential H_2S release rate is less than 2.0 m^3/s and the calculated emergency planning zone (EPZ) does not intersect an urban centre, and
- the geological prognosis of the proposed well is clearly established on the basis of offset wells, and
- normal formation pressures are expected, and
- no significant loss circulation is expected.

The secondary unit may be either an atmospheric open-bottom degasser (that meets the criteria set out in Section 2.1.2.4[a] for primary degassers) or an enclosed degasser.

Since enclosed degassers are not commonly found on drilling rigs, design specifications are not provided in this guide. Design specifications of enclosed degassers are available in *IRP Volume 1*, Section 1.7: Mud Gas Separators.

2.1.2.4(c) Degasser Inlet

The degasser inlet line(s) from the choke manifold to the degasser must meet the following requirements:

- The degasser inlet line must have (as a minimum) a working pressure equal to that of the required BOP system (see Appendix 3).
- For wells drilled to a depth of not more than 1250 m, the degasser inlet line(s) must be (as a minimum) the same size or larger than the choke size in use. (See Appendix 3 for minimum choke size.)
- For wells drilled deeper than 1250 m, the degasser inlet line(s) must be (as a minimum) 25.4 mm larger than the minimum required choke size. (See Appendix 3 for minimum choke size.) If a larger choke is installed, then the inlet line to the degasser must be (as a minimum) the same diameter.
- The degasser inlet line must be properly made up and connected to the manifold and the degasser at all times.
- Connections must be made using flanges, threaded fittings, or hammer unions.
- The degasser inlet line(s) may contain directional changes provided they are made with right-angle (90°) connections constructed of tees and crosses blocked on fluid turns.
- Directional changes in the degasser inlet line(s) may also be made using flexible hose, provided the hose meets the requirements set out in Section 3.3: Degasser Inlet Line(s).
- The degasser inlet line must be void of fluid traps, blown out with air, heated, or filled with a nonfreezing fluid that is miscible with water during cold weather operations.

- Valves or other mechanical restrictions are not permitted in the degasser inlet line. (In-line glycol recovery drainage ports are acceptable provided they do not compromise system integrity or function.)

- The degasser inlet line must be accessible full length, and no portion of the line may be submerged in drilling fluid.

- The section of the degasser inlet line from the manifold to the mud tank must be secured at 10 m intervals, and the segment running vertically adjacent to the mud tank wall must be secured in place.

- Prior to assembly, all connections between the choke manifold and the degasser must be visually inspected. After assembly of the connections, an inspection must be conducted to ensure proper make-up. The results of the inspections must be recorded in the drilling tour book.

- For critical sour wells (when two degassers are deployed), a separate degasser inlet line from each manifold wing to each degasser is required.

- Degasser inlet lines for critical sour wells must meet *NACE MR0175* standards (latest edition).

2.1.2.4(d) Degasser Vent Line

The degasser vent line must meet the following requirements:

- The vent line must be designed of a suitable material composition so that it maintains its shape, maintains a seal at the connections (no leaks), and has a steel end (minimum of 9 m) to prevent burn back.

- The vent line must be properly made up and connected to the degasser at all times.

- Vent line(s) connections may include flanged, hammer union, threaded, inflatable air union, clamp type, irrigation, or other suitable connections.

- Directional changes in the vent line(s) may be made with radiused bend fittings or flexible hose(s) provided the hose(s) meets the requirements set out in Section 3.4: Degasser Vent Line.

- The vent line(s) must be either self-draining or have some means incorporated to ensure that fluid can be drained from the line(s) (the vent line must be void of fluids during drilling operations). Precautions must be taken to minimize environmental impact from spillage.

- The vent line must be accessible full length, and no portion of the line may be submerged in drilling fluid.

- The section of the line running vertically adjacent to the mud tank wall must be rigidly secured in place. The remainder of the degasser vent line does not require securing.

- Wall thickness and internal diameter must be consistent throughout the entire vent line.

- The vent line must terminate in a flare pit located at least 50 m from the well.

- For vent line sizing specifications, refer to Table 1.

- For critical sour wells (when two degassers are deployed), each degasser must have a separate vent line to the flare pit or flare tank.

- Vent lines for critical sour wells must meet *NACE MR0175* standards (latest edition).

2.1.3 Flare Pits

The flare pit must

- be constructed to contain a minimum of 8 m^3 of fluid;

- have side and back walls rising not less than 2 m above ground level;

- be constructed to resist the erosion of a high-pressure flow of gas or liquid; and

- be located a minimum distance of 50 m from the well.

2.1.4 Flare Tanks

For all classes of wells, the following minimum standards apply to flare tanks:

- All flare tanks must be constructed of steel to ensure fluid containment during prolonged exposure to extreme heat. Structural integrity of the flare tank must be maintained.

- The flare tank wall directly opposite all flare/diverter line(s) connected to the flare tank must include an impingement plate to resist erosion from high-velocity gas, liquids, and solids.

- Flare tanks must have a minimum of 8 m^3 capacity.

- Flare tanks must be open to atmosphere.

- The flare tank must be positioned a minimum distance of 50 m from the well. (For exceptions to this requirement, see *ID 91-3: Heavy Oil/Oil Sands Operations* or *Guide 8: Surface Casing Depth Minimum Requirements,* Section 1.1.)

- The flare tank must be equipped with a minimum 76.2 mm liquid loading steel line that is connected at all times for the purpose of drawing fluids from the tank. The connection point of the loading line must extend a minimum of 9 m from the flare tank.

- Atmospheric open-bottom mud-gas separator(s) vent lines must be kept separated from the liquid in the flare tank and designed so that fluid can be drained from the line(s) following use. The line(s) may be laid on the ground next to the flare tank, provided no fire hazard exists.

2.2 Kill System

2.2.1 Class I Wells

Class I wells do not require a kill system.

2.2.2 Well Classes II-IV

The blowout prevention system for well classes II-IV must include a kill system for the purpose of pumping fluid into the well.

The kill system consists of a kill line(s), which is the line(s) from the mud line/standpipe to the BOPs and all associated valves (including the mud line/standpipe isolation valve).

The kill system must meet the following requirements:

- The kill line(s) must meet the minimum specifications (size, number of lines, etc.) for the class of well being drilled (see Appendix 3).
- The kill system must have (as a minimum) two flanged valves installed on the drilling spool(s) (see Appendix 3).
- Piping extensions or fluid turns are not permitted between the drilling spool and the first manual valve. This valve must be connected directly to the drilling spool (see Appendix 3).
- The kill system must have the same pressure rating (as a minimum) as the required BOP system from the drilling spool connection up to and including the isolation valve(s) on the mud line/standpipe connection.
- The kill line(s) must be valved to isolate the mud line/standpipe from the kill line(s).
- Connections from the last valve on the drilling spool(s) to the mud line/standpipe may be made using flange, clamp type, threaded fittings, or hammer unions.
- All flange, clamp type, threaded fittings, and hammer union connections used in the kill system must be properly installed and made up (this includes all studs, bolts, and nuts, etc.).
- The kill line(s) should be connected at all times or easily connected by making up one connection.
- The valve next to the drilling spool must be in the closed position during normal drilling operations.
- All valves in the kill system must be operable with the valve handle(s) in place at all times.

- Flexible hose(s) may be used in the kill line(s) provided the hose meets the requirements set out in Section 3.1: Bleed-off, Kill, or Diverter Line(s).

2.2.2.1 Well Classes V and VI and Critical Sour Wells

In addition to the requirements set out above in Section 2.2.2, for well classes V and VI and critical sour wells, the following requirements must also be met:

- A separate kill line must be installed from the mud line/standpipe connection to each drilling spool so fluid can be pumped into either or both spools.

- A flanged check valve must be installed on each kill line (see Appendix 3).

- For critical sour wells, the kill lines must meet *NACE MR0175* standards (latest edition).

3 Flexible Hoses

3.1 Bleed-off, Kill, or Diverter Line(s)

Flexible hose(s) may be installed in the bleed-off, kill, or diverter line(s) provided the hose(s) meets the following requirements:

- The flexible hose must have (as a minimum) a working pressure equal to that of the required BOP system (see Appendix 3).
- The hose must have an internal diameter that meets the requirements for the class of well as outlined in Appendix 3.
- The hose must have factory-installed connections.
- The hose must be fire sheathed to provide an adequate fire-resistant rating if used within 7 m of the well. Adequate fire-resistant sheathing for flexible hoses used in the bleed-off, kill, or diverter line(s) is defined as a hose assembly that can withstand a minimum of 30 minutes of 700°C flame temperature at maximum working pressure without failure.
- The hose must maintain its original shape and not contain bends with a radius less than the manufacturer's specified minimum bending radius.
- The hose must be marked so that the manufacturer can be readily identified.
- The hose must be supported to prevent stresses on connecting valves and piping.
- The hose must be secured and protected from mechanical damage.
- Flexible hose(s) used in the diverter line(s) are not permitted within 9 m of the flare pit or flare tank.
- For critical sour wells, the metallic components of the flexible hose(s) must meet *NACE MR0175* standards (latest edition).
- For critical sour wells, the elastomeric components of the flexible hose(s) must meet *NACE TM 0187-87* standards (latest edition).
- The hose must be shop serviced and tested once every three years. Certification must be available at the rig. (See Appendix 5: Shop Servicing and Testing of Blowout Preventers, BOP Spools, and Flexible Bleed-off and Kill-line Hoses.)

3.2 Flare and Emergency Flare Line(s)

Flexible hose(s) may be installed in the flare and emergency flare line(s) provided the hose(s) meets the following requirements:

- The hose must have (as a minimum) a working pressure equal to that of the required BOP system (see Appendix 3).

- The hose must have a minimum nominal diameter of 76.2 mm throughout.
- The hose must have factory-installed connections.
- The hose must maintain its original shape and not contain bends with a radius less than the manufacturer's specified minimum bending radius.
- The hose must be supported, secured, and protected from mechanical damage.
- The hose must be fire sheathed to provide an adequate fire-resistant rating if used within 7 m of the well. Adequate fire-resistant sheathing for flexible hoses used in the flare or emergency flare line(s) is defined as a hose assembly that can withstand a minimum of 30 minutes of 700°C flame temperature at maximum working pressure without failure.
- Flexible hose(s) used in the flare or emergency flare line(s) are not permitted within 9 m of the flare pit or flare tank.
- For critical sour wells, the metallic components of the flexible hose(s) must meet *NACE MR0175* standards (latest edition).
- For critical sour wells, the elastomeric components of the flexible hose(s) must meet *NACE TM 0187-87* standards (latest edition).

An emergency flare line is required in the high hazard area and for type 3 and 4 surface casing reductions (see Section 14).

3.3 Degasser Inlet Line(s)

Flexible hose(s) may be installed in the inlet line(s) provided the hose(s) meets the following requirements:

- The hose must have (as a minimum) a working pressure equal to that of the required BOP system (see Appendix 3).
- The hose must be the same size as the required inlet line(s) (see Table 1 in Section 2.1.2.4).
- The hose must have factory-installed connections.
- The hose must be fire sheathed to provide an adequate fire-resistant rating if used within 7 m of the well. Adequate fire-resistant sheathing for flexible hoses used in the degasser inlet line(s) is defined as a hose assembly that can withstand a minimum of 30 minutes of 700° C flame temperature at maximum working pressure without failure.
- The hose must maintain its original shape and not contain bends with a radius less than the manufacturer's specified minimum bending radius.
- The hose must be supported to prevent stresses.

- The hose must be secured and protected from mechanical damage.
- For critical sour wells, the metallic components of the flexible hose(s) must meet *NACE MR0175* standards (latest edition).
- For critical sour wells, the elastomeric components of the flexible hose(s) must meet *NACE TM 0187-87* standards (latest edition).

3.4 Degasser Vent Line

Flexible hose(s) may be installed in the vent line(s) provided the hose(s) meets the following requirements:

- The hose must be the same internal diameter throughout as the required vent line(s) (see Table 1 on page 24).
- The hose must maintain its original shape throughout the entire length of the hose.
- Flexible hose(s) used in the vent line(s) are not permitted within 9 m of the flare pit or flare tank.
- For critical sour wells, the metallic components of the flexible hose(s) must meet *NACE MR0175* standards (latest edition).
- For critical sour wells, the elastomeric components of the flexible hose(s) must meet *NACE TM 0187-87* standards (latest edition).

4 Winterizing

4.1 Winterizing BOP, Accumulator, Bleed-off, and Kill Systems

During cold weather drilling operations:

- sufficient heat must be provided to the BOP stack, all associated valves, choke manifold, and accumulator system to maintain their effectiveness.

- The bleed-off, kill, flare, and degasser inlet line(s) must be
  - empty,
  - filled with a nonfreezing fluid (e.g., antifreeze) that is miscible with water, or
  - heated.

5 BOP Control Systems

5.1 Accumulator System

All BOPs must be hydraulically operated and connected to an accumulator system.

The accumulator system must meet the following requirements:

- For class I wells, it must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the hydraulically operated valve (HCR) on the bleed-off line and close the annular preventer on drill pipe and retain a minimum pressure of 8400 kPa on the accumulator system.

- For well classes II, III, and IV, it must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on drill pipe, close one ram preventer require and retain a minimum pressure of 8400 kPa on the accumulator system.

  In addition to the above functions, the accumulator system for CTUs must also provide sufficient volume and pressure to shear the coiled tubing and retain on the accumulator system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater (sizing calculations required; see Section 5.5).

  If the existing accumulator system cannot meet these requirements because of the closing volume requirements for the shear ram, the accumulator system's capacity and/or pressure must be increased or a separate accumulator system must be installed. It is also acceptable to supplement the existing accumulator system with a nitrogen (N_2) booster that will provide sufficient volume and pressure to shear the coiled tubing and retain a minimum accumulator pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.

- For well classes V and VI, it must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close two ram preventers, and retain a minimum pressure of 8400 kPa on the accumulator system.

  In addition to the above functions, the accumulator system for CTUs must also provide sufficient volume and pressure to shear the coiled tubing and retain on the accumulator system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater (sizing calculations required; see Section 5.5).

  If the existing accumulator system cannot meet these requirements because of the closing volume requirements for the shear ram, the accumulator system's capacity and/or pressure must be increased or a separate accumulator system must be installed. It is also acceptable to supplement the existing accumulator system with a nitrogen (N_2) booster that will provide sufficient volume and pressure to shear the coiled tubing and retain a minimum accumulator pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.

- For critical sour wells, it must be capable of providing, without recharging, hydraulic fluid of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close, open, and close one ram preventer, and if blind/shear rams are installed, provide sufficient volume and pressure to shear the drill pipe and retain on the accumulator system a minimum pressure of 8400 kPa or the minimum pressure required to shear the drill pipe, whichever is greater (sizing calculations required; see Section 5.5).

  If the existing accumulator system cannot meet these requirements because of the addition of the blind/shear rams, the accumulator system's capacity and/or pressure must be increased or a separate accumulator system must be installed. It is also acceptable to supplement the existing accumulator system with a nitrogen (N_2) booster that will provide sufficient volume and pressure to shear the drill pipe and retain a minimum accumulator pressure of 8400 kPa or the minimum pressure required to shear the drill pipe, whichever is greater.

- It must be installed and operated in accordance with the accumulator manufacturer's specifications. All accumulator specifications must be available at the rig (e.g., manufacturer, number of bottles, capacity of bottles, design pressure).

- It must be connected to the blowout preventers and the HCR on the bleed-off line, with hydraulic lines (steel and/or nonsteel) of working pressure equal to or greater than the working pressure of the accumulator.

- All nonsteel accumulator hydraulic lines located within 7 m of the wellbore must be completely sheathed with adequate fire-resistant sheathing.

  Adequate fire-resistant sheathing for hydraulic BOP hoses is defined as a hose assembly that can withstand a minimum of 5 minutes of 700°C flame temperature at maximum working pressure without failure.

- The accumulator system must be recharged by an automatic pressure-controlled pump capable of recovering, within 5 minutes, the accumulator pressure drop resulting from the function test (see Section 5.4.1) of the BOP components (for the required well class) and the HCR on the bleed-off line.

  For well classes V and VI and critical sour wells, the accumulator system must be equipped with two separate automatic pressure-controlled recharge pumps.

- A check valve must be installed in the accumulator hydraulic system for all well classes. The check valve must be located between the accumulator charge pump(s) and the accumulator bottles. This will allow for a change out of the charge pump(s) in the event of a pump failure after the system has been energized.

- The accumulator system must be capable of closing any ram type BOP within 30 seconds.

- It must be capable of closing any annular type BOP of a size up to and including 350 mm bore diameter within 60 seconds.

- It must be capable of closing any annular type BOP of a size greater than 350 mm bore diameter within 90 seconds.

- It must be equipped with a gauge to determine accumulator system pressure.
- It must be equipped with readily accessible fitting(s) and gauge to determine the precharge pressure of the accumulator bottles.
- It must be readily accessible.
- It must be housed to ensure the system can be protected from the well in the event of an uncontrolled flow.
- It must be adequately heated to maintain the accumulator's effectiveness.
- It must be located at least 15 m from the wellbore.
- The vent on the accumulator reservoir must be installed in such a manner that venting takes place outside the building (side or top of building).
- The accumulator system must be connected to a backup nitrogen system.

5.1.1 Additional BOP Equipment

If additional BOP equipment has been installed and is in use, there must be sufficient usable hydraulic fluid available to close the additional BOP component(s) and meet the requirements of Section 5.1.

All additional BOP equipment that is not in service must be "locked out" (e.g., unplugged, handles removed, lines disconnected).

5.2 Backup Nitrogen (N_2) System

- For class I wells, the accumulator system must be connected to a backup N_2 system that must be capable of providing N_2 of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, and retain a minimum pressure of 8400 kPa on the backup N_2 system.
- For well classes II, III, and IV, the accumulator system must be connected to a backup N_2 system that must be capable of providing N_2 of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close one ram preventer, and retain a minimum pressure of 8400 kPa on the backup N_2 system.

  In addition to the above functions, CTUs must also provide sufficient volume and pressure to shear the coiled tubing and retain on the backup N_2 system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.

  If the existing backup N_2 system cannot meet these requirements because of the closing volume requirements of the shear ram, the backup N_2 system's capacity and/or pressure must be increased or a separate backup N_2 system must be installed. It is also acceptable to supplement the existing backup N_2 system with an N_2 booster (this may be the same N_2 booster system that supplements the accumulator).
- For well classes V and VI, the accumulator system must be connected to a backup N_2 system that must be capable of providing N_2 of sufficient volume and pressure to

open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close two ram preventers, and retain a minimum pressure of 8400 kPa on the backup N_2 system.

In addition to the above functions, CTUs must also provide sufficient volume and pressure to shear the coiled tubing and retain on the backup N_2 system a minimum pressure of 8400 kPa or the minimum pressure required to shear the coiled tubing, whichever is greater.

If the existing backup N_2 system cannot meet these requirements because of the closing volume requirements of the shear ram, the backup N_2 system's capacity and/or pressure must be increased or a separate backup N_2 system must be installed. It is also acceptable to supplement the existing backup N_2 system with an N_2 booster (this may be the same N_2 booster system that supplements the accumulator).

- For critical sour wells, the accumulator system must be connected to a backup N_2 system that must be capable of providing N_2 of sufficient volume and pressure to open the HCR on the bleed-off line, close the annular preventer on the drill pipe, close, open, and close one ram preventer, and if blind/shear rams are installed, provide sufficient volume and pressure to shear the drill pipe and retain on the backup N_2 system a minimum pressure of 8400 kPa or the minimum pressure required to shear the drill pipe, whichever is greater.

  For critical sour wells, if the existing backup N_2 system cannot meet these requirements because of the addition of the blind/shear rams, the backup N_2 system's capacity and/or pressure must be increased or a separate backup N_2 system must be installed. It is also acceptable to supplement the existing backup N_2 system with an N_2 booster (this may be the same N_2 booster system that supplements the accumulator).

- The accumulator system must be connected to a backup N_2 system that must be connected so that it will operate the BOPs and HCR on the bleed-off line, as described above, and not allow the N_2 to discharge into the accumulator reservoir or the accumulator bottles (see Appendix 3).

  When the backup N_2 system is tied in downstream of an accumulator regulator valve(s), isolation valves are required to prevent venting of N_2 through the regulator into the accumulator reservoir tank.

In addition, the accumulator system must be connected to a backup N_2 system that must be

- equipped with a gauge or have a gauge readily available for installation to determine the backup N_2 pressure;
- readily accessible;
- housed to ensure that the system can be protected from the well in the event of an uncontrolled flow;
- adequately heated to maintain the backup N_2 system effectiveness; and
- located at least 15 m from the wellbore.

5.2.1 Additional BOP Equipment

If additional BOP equipment has been installed and is in use, there must be sufficient usable backup N_2 available to close the additional BOP component(s) and meet the requirements of Section 5.2.

All additional BOP equipment that is not in service must be "locked out" (e.g., unplugged, handles removed, lines disconnected).

5.3 BOP Controls

The accumulator system must include operating controls at the floor (driller's position) and remote positions for each BOP and the HCR on the bleed-off line.

5.3.1 Floor Controls

Each BOP component and the HCR in the bleed-off line must have a separate control located near the driller's position.

The BOP floor operating controls must also be

- capable of opening and closing each BOP component and the HCR in the bleed-off line;
- properly installed, readily accessible, correctly identified, and show function operations (i.e., open and close); and
- equipped with a gauge indicating the accumulator system pressure.

5.3.2 Remote Controls

Each BOP component and the HCR in the bleed-off line must have a separate control located at the remote position (typically located at the accumulator).

The BOP remote operating controls must also be

- capable of opening and closing each BOP component and the HCR;
- properly installed, correctly identified, and show function operations (i.e., open and close);
- equipped with a gauge to determine the accumulator system pressure;
- located a minimum of 15 m from the well;
- readily accessible and housed to ensure that the remote controls can be adequately heated and protected from the well in the event of an uncontrolled flow; and
- adequately heated.

5.3.3 Master Hydraulic Control Manifold Location

The master hydraulic control manifold contains all of the four-way valves and regulators that control the open and close functions of the BOPs and the HCR on the bleed-off line. The four-way valve directs accumulator hydraulic fluid under pressure to the BOPs.

For critical sour wells, the master hydraulic control manifold must be located at the remote position.

For well classes I to VI (noncritical), it is preferable, but not mandatory, that the master hydraulic control manifold be located at the remote position (typically located at the accumulator).

5.4 BOP Function Test

Function test requirements include checking the function of the BOPs, the HCR on the bleed-off line, the accumulator, and the recharge pump.

All BOP components and the HCR on the bleed-off line must operate from both the floor and remote controls.

5.4.1 Procedure

When conducting a BOP function test, the following procedures must be followed:

- If there is no drill pipe in the well, have the crew run in a single joint in order to function test the annular and pipe rams.
- Have the crew drain the BOP stack (summer and winter). During winter operations, have the crew close the manual valve in the bleed-off line (for the function test only) to ensure that no drilling fluid enters the line (or, if antifreeze is used in the line, it is not lost from the line).
- Have the crew shut off the accumulator recharge pump. The accumulator system pressure at the time of the inspection must be used for the BOP function test. The accumulator must not be recharged prior to conducting the test.
- Observe and record the accumulator pressure.
- Have the function test conducted using the BOP controls that actuate the hydraulic four-way valve controls on the master hydraulic control manifold.
- For class I wells, have the crew open the HCR on the bleed-off line and close the annular preventer.
- For well classes II to VI, have the crew open the HCR on the bleed-off line, close the annular preventer, and close the pipe ram preventer(s) (both sets if required or in use).
- For critical sour wells, have the crew open the HCR on the primary bleed-off line (both HCRs if two are in use), close the annular preventer, close both sets of pipe ram preventers, and open one ram preventer.

- Observe and record the closing times.

  The allowed closing time is 30 seconds for the rams, 60 seconds for annular preventers up to 350 mm, and 90 seconds for annular preventers over 350 mm.

- Visually check the position of the annular, rams, and the HCR (to ensure that they functioned properly).

- After the function test is completed, observe and record the accumulator pressure. The accumulator pressure must not drop below 8400 kPa.

  For critical sour wells and CTUs, if blind/shear rams are installed, an accumulator sizing calculation must be conducted (see Section 5.1 and Appendix 7, sample calculation #2, for critical sour wells).

- Have the crew turn on the recharge pump. The accumulator must recharge to the original starting pressure (the accumulator pressure at which the BOP function test started) within 5 minutes.

- Have the crew open the pipe rams, open the annular, close the HCR, and open the manual valve on the bleed-off line.

- Have the crew remove the single joint of drill pipe from the well (if one was run).

- Have the crew function test the blind rams to ensure that they function properly (if no pipe in the hole).

5.4.2 Daily and Weekly

The BOPs must be function tested as follows:

- The annular(s) and pipe rams must be function tested daily (as a minimum).
- Blind rams must be function tested daily when the drill string is out of the hole.
- The HCR must be function tested weekly (as a minimum).
- For wells with a diverter system installed, the annular and HCR must be function tested prior to commencement of drilling.

5.4.3 Recording

The actual BOP components function tested by the crews must be recorded in the drilling logbook (e.g., annular preventer function tested – annular fully closed in 20 seconds).

5.5 Accumulator Sizing Calculations

The inspector must complete accumulator-sizing calculations when a function test as outlined above cannot be conducted and when blind/shear rams are in use (critical sour wells and CTUs).

Accumulator sizing calculations are performed to determine if the accumulator can provide sufficient usable hydraulic fluid at a minimum pressure of 8400 kPa (or when blind/shear rams are in use, the minimum pressure required to shear the drill pipe, whichever is greater) to effectively close the required BOP components, open the HCR on the bleed-off line, and operate any additional BOP equipment in use with the accumulator recharge pump turned off.

Usable hydraulic fluid is defined as the stored hydraulic fluid available at a minimum pressure of 8400 kPa (or when blind/shear rams are in use, the minimum pressure required to shear the drill pipe, whichever is greater).

5.5.1 System Specifications

The inspector must determine and record the accumulator system's make, design pressure, accumulator system pressure (upstream of any regulators), accumulator bottle size(s), number of accumulator bottles, and total accumulator volumetric capacity (see Table 2: Accumulator Bottle Capacity [page 44]). The accumulator system pressure at the time of the inspection must be used for the accumulator sizing calculations.

When conducting an accumulator sizing calculation, the inspector should complete a Drilling BOP/Accumulator/Backup Nitrogen Data worksheet (see Worksheet No. 1: BOP/Accumulator/Backup Nitrogen Data, page 45).

5.5.2 Determining Precharge Pressure

The inspector must have the crew check the precharge pressure (if wellbore conditions allow) on each accumulator bottle to determine the average precharge pressure. This requires depressurizing the accumulator. The inspector must record the average pressure (see Table 3: Manufacturer's Recommended Precharge Pressures).

5.5.3 Determining Usable Accumulator Hydraulic Fluid Volume at a Minimum Pressure of 8400 kPa

Two methods are provided:

- Method 1 uses a graph and is the preferred method to be used during inspections because of its simplicity.
- Method 2, in Appendix 7, is the alternate method and requires more detailed calculations. The graph used in Method 1 is derived from the equations shown in Method 2.

If a blind/shear ram is in use (critical sour wells and CTUs) accumulator sizing calculations must be conducted using Method 2 (see Appendix 7, sample calculation 2, for critical sour wells).

5.5.4 Method 1

Determine usable accumulator fluid volume above 8400 kPa using Figure 1 and the following steps:

- Using Figure 1, plot the accumulator system pressure and the average precharge pressures (obtained from Sections 5.5.1 and 5.5.2 respectively).
- Follow the accumulator system pressure line on the graph until it intersects with the vertical precharge pressure line.
- Then follow on the horizontal line to the left vertical axis of the graph and read the percentage (0-60%) from "Percent of Accumulator Fluid Usable Above 8400 kPa."
- Calculate usable accumulator hydraulic fluid available at a minimum pressure of 8400 kPa by multiplying the percentage (determined above) by the volumetric capacity of the accumulator bottle(s) (as determined from Section 5.5.1).

  Usable accumulator hydraulic fluid available (at a minimum pressure of 8400 kPa)
  = Percentage x Total accumulator volumetric capacity

5.5.5 Determining BOP Component Hydraulic Fluid Requirements

Determine the total hydraulic fluid volume needed to close the required BOP components and open the HCR on the bleed-off line (see Appendix 9: BOP Fluid Volume Requirements). Include the volume required to operate any additional BOP components in use.

5.5.6 Completing the Sizing Calculation

Compare the total fluid volume needed to close the required BOP components (and any additional BOP equipment in use) and open the HCR on the bleed-off line with the volume of usable accumulator hydraulic fluid at a minimum pressure of 8400 kPa, calculated earlier.

- The accumulator is adequately sized if the calculated usable fluid volume available (at a minimum pressure of 8400 kPa) is greater than the fluid volume needed to close the required BOP components, open the HCR on the bleed-off line, and operate any additional BOP equipment in use (see Example 1: Accumulator Sizing Calculation below).

Example 1. Accumulator Sizing Calculation

Rig Accumulator Specifications

Accumulator:	151.6 litres (L)
Operating pressure:	21 mPa
Precharge pressure:	7 mPa

Calculated Usable Fluid at a Minimum Pressure of 8400 kPa

Percentage of usable fluid (above 8400 kPa) available at current operating pressures (as determined from Figure 1) = 50 %

Usable accumulator hydraulic fluid available (above 8400 kPa)
= Percent x Total accumulator volumetric capacity

$$\frac{50}{100} \times 151.6 = 75.8 \text{ L}$$

Total Usable Fluid at a Minimum Pressure of 8400 kPa = 75.8 L

Rig BOP (21 mPa) Component Volumes

254 mm Hydril GK Annular BOP	closing volume required = 28.1 L
254 mm Hydril Manual Lock Pipe Rams*	closing volume required = 12.5 L
101.6 mm Cameron HCR	opening volume required = 2.0 L
Total Closing/Opening Volume Required	**= 42.6 L**

Accumulator Sizing Results

The accumulator is adequately sized, since the usable fluid volume available at a minimum pressure of 8400 kPa (75.8 L) exceeds the fluid volume required (42.6 L) to close the annular, pipe rams, and open the HCR.

---

* If two sets of pipe rams are required or in service, the closing volume for each set must be included in the calculations.

Table 2. Accumulator bottle capacity[1]

Cylindrical								Spherical	
5 gal bottles[2]	litres[3]	10 gal bottles[2]	litres[3]	11 gal bottles[2]	litres[3]	15 gal bottles[2]	litres[3]	80 gal bottles[2]	litres[3]
1	15.1	1	34.1	1	37.9	1	53.0	1	299.0
2	30.3	2	68.1	2	75.7	2	106.0	2	598.1
3	45.4	3	102.2	3	113.6	3	159.0	3	897.1
4	60.6	4	136.3	4	151.4	4	212.0	4	1196.2
		5	170.3	5	189.3	5	265.0		
		6	204.4	6	227.1	6	318.0		
		7	238.5	7	265.0	7	371.0		
		8	272.5	8	302.8	8	424.0		
		9	306.6	9	340.7	9	477.0		
		10	340.7	10	378.5	10	530.0		

[1] Accumulator bottles are sized in U.S. gallons (U.S. gallons x 3.7854 = litres). One U.S. gallon has been subtracted from the nominal size of each accumulator bottle to account for the displacement of the bladder or float assembly (required when determining accumulator volumetric capacity).

[2] Nominal volume in U.S. gallons.

[3] Actual volume in litres (one U.S. gallon has already been subtracted from these bottles prior to converting to litres).

Table 3. Manufacturer's recommended precharge pressures[1]

Accumulator system operating pressure (kPa)	Recommended Precharge Pressure (± 10%) (kPa)
10 500	5250
14 000	7000
21 000	7000

[1] When conducting accumulator-sizing calculations, the accumulator is considered adequate, regardless of its precharge pressure, if sufficient usable fluid is available to complete the required BOP function tests and maintain a minimum pressure of 8400 kPa on the accumulator system.

Worksheet No. 1: BOP/Accumulator/Back-up N_2 Data

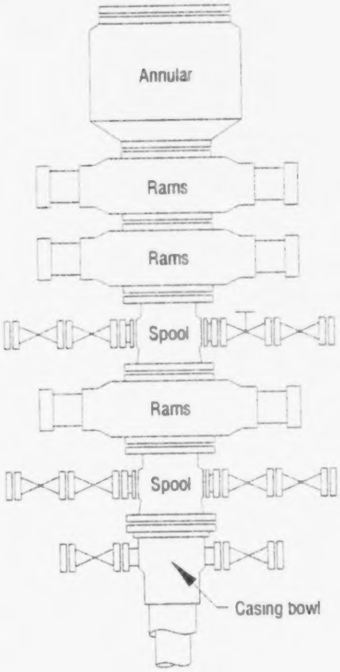
BOP Data

CONTRACTOR ____________________ RIG No. ________ STACK: PRESSURE RATING ____________ kPa

SIZE ____________________ mm

NACE TRIM ____________________

NACE CERTIFIED ____________________



Annular
MAKE ____________ MODEL ____________
CLOSING VOLUME ____________________ LITRES

Ram : Pipe
MAKE ____________ MODEL ____________
CLOSING VOLUME ____________________ LITRES

Ram : Blind
MAKE ____________ MODEL ____________
CLOSING VOLUME ____________________ LITRES

HCR :
MAKE ____________ SIZE ____________
OPENING VOLUME ____________________ LITRES

Ram : Pipe
MAKE ____________ MODEL ____________
CLOSING VOLUME ____________________ LITRES

TOTAL VOLUME ____________________ LITRES

ACCUMULATOR DATA

Make ____________________
Design pressure rating ____________________ (kPa)
Operating pressure ____________________ (kPa)
Bottle capacity ____________________ (L)
Number of bottles ____________________
Average precharge pressure ____________________ (kPa)
Total bottle capacity ____________________ (L)
Volume usable above 8400 kPa ____________________ (L)

NITROGEN BACKUP DATA

Number of bottles ____________________
Bottle capacity ____________________ (L)
Average N_2 pressure ____________________ (kPa)
Total bottle capacity ____________________ (L)
Volume usable above 8400 kPa ____________________ (L)

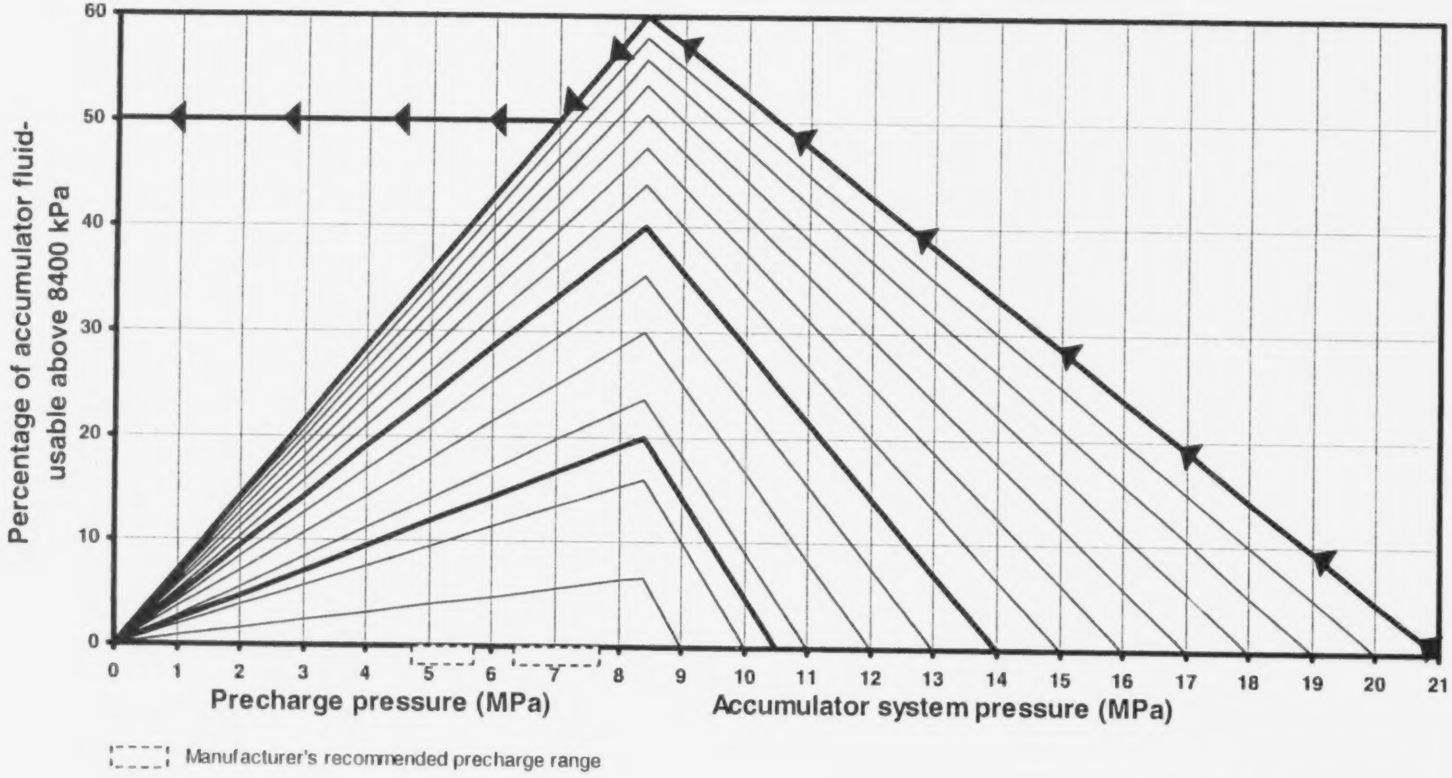


Figure 1. Usable accumulator fluid volume above 8400 kPa

5.6 Backup Nitrogen Sizing Calculations

The inspector must complete backup nitrogen (N_2) sizing calculations.

N_2 sizing calculations are conducted to determine if the backup N_2 system can provide sufficient usable N_2 at a minimum pressure of 8400 kPa (or the minimum pressure required to shear the drill pipe, whichever is greater when blind/shear rams are in use to effectively close the required BOP components, open the HCR on the bleed-off line, and operate any additional BOP equipment in use with the accumulator isolated.

Usable backup N_2 fluid is defined as the equivalent litres of stored N_2 available at a minimum pressure of 8400 kPa (or when blind/shear rams are in use, the minimum pressure required to shear the drill pipe, whichever is greater).

The following sections outline the information and procedures required to conduct backup N_2 sizing calculations.

5.6.1 System Specifications

The inspector must determine and record the number, capacity and average pressure of the backup N_2 bottle(s) in service (see Figure 2: Usable N_2 Fluid Volume Above 8400 kPa).

A Drilling BOP/Accumulator/Backup Nitrogen Data worksheet should be completed (see Worksheet No. 1: Drilling BOP/Accumulator Data).

5.6.2 Determining Usable Backup N_2 Fluid Volume at a Minimum Pressure of 8400 kPa

Two methods are provided:

- Method 1 uses a graph and is the preferred method to be used during inspections because of its simplicity (see Section 5.6.3). As illustrated in this section, this method assumes that all N_2 bottles are the same size.

- Method 2, shown in Appendix 8, is the alternate method and requires more detailed calculations. The graph used in Method 1 is derived from the equations shown in Method 2.

If a blind/shear ram is in use (critical sour wells and CTUs), backup N_2 sizing calculations must be conducted using Method 2 (see Appendix 8, example 2).

5.6.3 Method 1

Determine usable backup N_2 fluid volume at a minimum pressure of 8400 kPa using Figure 2 and the following steps:

- Using Figure 2, plot the average pressure of the bottle(s) in service on the left vertical axis.

- Draw a horizontal line to the right until it intersects the actual bottle size line in use.

- Then, draw a perpendicular line from this intersection point down to the horizontal axis.

- Read the equivalent litres of usable N_2 off the horizontal axis.

- Now multiply the number of bottle(s) by the equivalent litres of usable N_2.

  Equivalent litres of usable N_2*, (at a minimum pressure of 8400 kPa)*
  = Equivalent litres of usable N_2 *x number of backup* N_2 *bottle(s)*

5.6.4 Determining BOP Component Backup N_2 Requirements

Determine the total fluid volume needed to close the required BOP components and open the HCR on the bleed-off line (see Appendix 9). Include the volume required to operate any additional BOP equipment in use.

5.6.5 Completing the Sizing Calculation

Compare the total fluid volume needed to close the required BOP components, open the HCR on the bleed-off line, and operate any additional BOP equipment in use with the volume of equivalent litres of usable backup N_2 at a minimum pressure of 8400 kPa calculated earlier.

- The backup N_2 supply is adequate if the calculated equivalent litres of usable backup N_2 is greater than the fluid volume required to close the required BOP components, open the HCR on the bleed-off line, and operate any additional BOP equipment in use (see Example 2: Backup N_2 Sizing Calculation).

Example 2. Backup N_2 Sizing Calculation

Rig N_2 Specifications

Number of bottles:	2
Bottle capacity:	42 L
Bottle 1 pressure:	17.5 mPa
Bottle 2 pressure:	14.0 mPa

Determine Average Bottle(s) Pressure

$$\text{Average bottle pressure} = \frac{17.5\ \text{mPa} + 14.0\ \text{mPa}}{2\ \text{bottles}} \qquad \mathbf{= 15.75\ mPa}$$

Calculated Equivalent Litres of Usable N_2 at a Minimum Pressure of 8400 kPa

Equivalent litres of usable N_2 per bottle at a minimum pressure of 8400 kPa = **37 L**
(as determined from Figure 2)

Total equivalent litres of usable N_2 (at a minimum pressure of 8400 kPa)
= equivalent litres of usable N_2 x number of backup N_2 bottle(s)

2 x 37.0 L **= 74.0 L**

Rig BOP (21 mPa) Component Volumes

254 mm Hydril GK-900 annular BOP	closing volume required	= 28.1 L
254 mm Hydril MPL Pipe rams*	closing volume required	= 12.5 L
101.6 mm Cameron HCR	opening volume required	= 2.0 L
	Total Closing/Opening Volume Required	**= 42.6 L**

Backup Nitrogen—Backup N_2 Sizing Results

The backup N_2 is adequately sized, since the equivalent litres of usable N_2 available at a minimum pressure of 8400 kPa (74.0 L) exceeds the N_2 volume required (42.6 L) to close the annular and pipe rams in service and open the HCR on the bleed-off line.

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* If two sets of pipe rams are required or in service, the closing N_2 volume for each set must be included in the calculations.

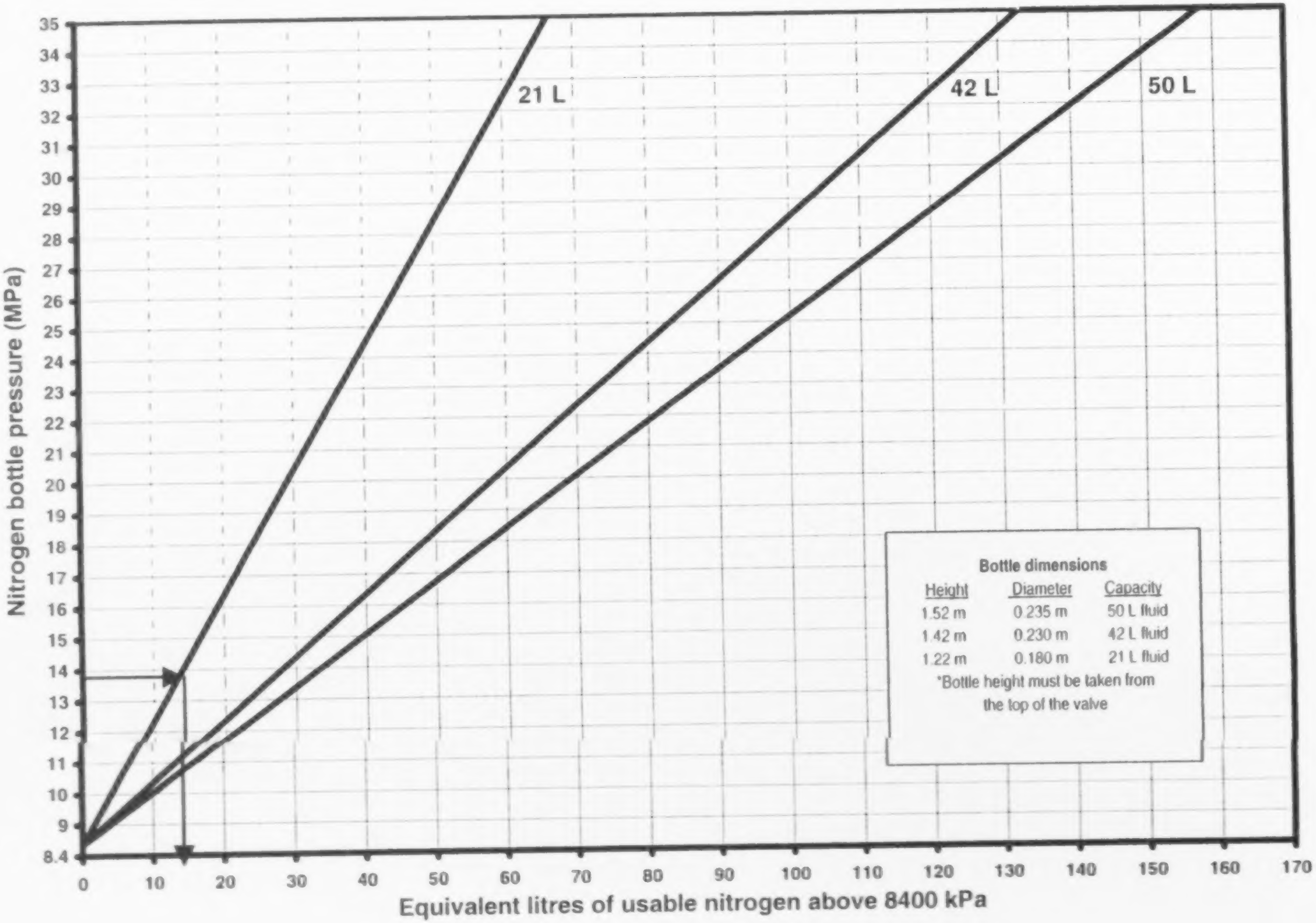


Figure 2. Usable nitrogen fluid volume above 8400 kPa

6 Pressure Testing

6.1 Pressure Testing

Prior to drilling out the surface, intermediate, and production casing, the licensee must ensure that the following components (when required) are pressure tested: each BOP, casing string, stabbing valve, inside BOP, lower kelly cock, choke manifold, bleed-off and kill lines and all associated valves.

6.1.1 Class I Wells

Class I wells do not require BOP pressure testing. However, a leak test of a minimal pressure is recommended.

6.1.2 Well Classes II to VI and Critical Sour Wells

For well classes II to VI and critical sour wells, pressure testing must be conducted as follows:

- The pressure test must be conducted using a low-viscosity fluid.
- The low-pressure test must be conducted before the high-pressure test.
- All valves in the choke manifold and bleed-off and kill systems must be individually pressure tested to confirm their isolation.

  Adjustable chokes do not require pressure testing. It is recommended that the adjustable chokes be confirmed as functional by pumping fluid through the chokes and noting restriction ability.
- The stabbing valve, inside BOP, and lower kelly cock (when required or in use) must be pressure tested from the bottom.

  An inside BOP consisting of pump-down check valve and a landing sub that is integral part of the drill string must also be pressure tested.
- A casing hanger plug must be run to isolate the casing (intermediate/production) if the required test pressure will exceed 67 per cent of the bottomhole pressure (BHP) at the casing setting depth.
- Variable bore rams must be pressure tested on the largest and smallest drill pipe sizes that will be used in the drill string.
- For a satisfactory pressure test, all components must maintain a stabilized pressure of at least 90 per cent of the required test pressure over a minimum 10-minute interval.
- All pressure test details (i.e., individual BOP components tested, test duration, low and high pressure test details) must be recorded in the drilling log book.

Third-party pressure test documentation is an acceptable substitute for detailed pressure test data entry in the drilling log book. This documentation must be available at the rig and referenced in the drilling log book.

Tables 4, 5, and 6 summarize the pressure testing requirements.

Table 4. Low-pressure testing requirements prior to drilling out surface, intermediate, or production casing

BOP equipment	Test pressure (kPa)	Test duration (minutes)
Annular	1400	10
Rams		
Bleed-off line and valves		
Manifold valves		
Kill line and valves		
Stabbing valve		
Inside BOP		
Lower kelly cock		
Surface casing		

Table 5. High-pressure testing requirements prior to drilling out surface casing

BOP equipment	Test pressure (kPa)	Test duration (minutes)
Annular	The lesser of 7000 kPa or 50 times (x) setting depth (m) of the surface casing	10
Rams		
Bleed-off line and valves		
Manifold valves		
Kill line and valves		
Stabbing valve		
Inside BOP		
Lower kelly cock		
Surface casing		

Table 6. High-pressure testing requirements prior to drilling out intermediate or production casing

BOP equipment	Test pressure (kPa)	Test duration (minutes)
Annular	50 per cent of the working pressure of the required BOP system for the well class (see Appendix 3)	10
Rams Bleed-off line and valves Manifold valves Kill line and valves Stabbing valves Inside BOP Lower kelly cock	To a minimum pressure of the required BOP system, based on the well class (depth of well) (see Appendix 3); e.g., Class III well: a minimum 14 000 kPa pressure test required	10
Intermediate or production casing	A pressure equal to 67 per cent of the BHP at the casing setting depth; if the actual BHP is unknown, a gradient of 11 kPa/m may be used for calculating a theoretical BHP (e.g., BHP = 11 kPa/m x casing setting depth)	10

7 Engines

7.1 Shutoff Devices

The purpose of shutoff devices on internal combustion engines (diesel, gasoline, propane, etc.) is to reduce potential sources of ignition in the event of a gas blow from the well by quickly shutting down the engines.

7.1.1 Diesel Engine(s)

Any diesel engine operating within 25 m of a well during the drilling operation must be equipped with one of the following:

- an air intake shutoff device(s) equipped with a remote control readily accessible at the driller's position;
- a system capable of injecting an inert gas into the engine's cylinders, which must be equipped with a remote control readily accessible at the driller's position;
- an air intake for the engine located at least 25 m from the well; or
- another approved device.

7.1.2 Gasoline Engine(s)

Any gasoline (including propane powered) engine operating within 25 m of a well during the drilling operation must be equipped with

- an ignition shutoff device equipped with a remote control readily accessible at the driller's station, or
- another approved device.

7.1.3 Vehicles Without Shutoff Devices

Internal combustion engines that operate on lease and are not equipped with an engine shutoff device may operate for a short duration within 25 m of a well provided that the licensee representative first assesses the on-site safety.

- This includes vehicles loading and unloading equipment, tubular goods, and supplies (such as water and fuel).
- This does not include vehicles that must remain operational while on lease, such as power tong trucks, logging trucks, and cementing trucks. These vehicles must be equipped with proper engine shutoff devices when operating within 25 m of a well.

7.1.4 Testing and Recording

For all well classes, all required internal combustion engine shutoff devices must be tested prior to drilling out the surface casing shoe and weekly thereafter.

For class I wells without surface casing set, engine shutoff devices must be tested prior to commencement of drilling operations and weekly thereafter.

Test results must be recorded in the drilling logbook.

For critical sour wells, all required internal combustion engine shutoff devices must be tested

- prior to drilling out the surface casing shoe and weekly thereafter,
- prior to drilling out the intermediate casing shoe and weekly thereafter, and
- within the 24-hour period prior to penetrating the critical zone. (If intermediate casing is set immediately above the critical zone, this would coincide with the above.)

Test results must be recorded in the drilling logbook.

7.1.5 Conducting Engine Shutoff Test(s)

When conducting any internal combustion engine shutoff test, the inspector must

- consult with the licensee representative to ensure that hole conditions are stable;
- ensure that the engine is idling;
- ensure that the engine being tested is isolated from other engines (clutches disengaged, etc.), so that each engine will stop independently; and
- ensure that the engine(s) power down rapidly and stop completely for the test(s) to be successful. (Engine lugging is not acceptable.)

7.2 Engine Exhaust

Any exhaust pipe from an internal combustion engine located within 25 m of any well, storage tank, or other source of ignitable vapours must be constructed so that

- any emergence of flame along its length or at its end is prevented;
- the end of the exhaust pipe is not closer than 6 m from the vertical centreline (projected upward) of the well; and
- the end of the exhaust pipe is not directed towards the well.

8 Mud Tanks and Fluid Volume Monitoring Systems

8.1 Mud Tanks

All wells being drilled must have mud tanks with an appropriate mud tank fluid volume monitoring system.

8.2 Mud Tank Fluid Volume Monitoring System

When drilling fluid returns are being directed to a mud tank, a fluid volume monitoring system must be in service. This applies to all well classes.

The system must be capable of measuring an imbalance in the volume of fluids entering and returning from the well.

8.2.1 Nonautomated (Nonelectronic) Fluid Level Monitors

For well classes I to IV, a nonautomated mud tank fluid volume monitoring system may be used (unless well licence provisions require an automated system). A nonautomated monitoring system may be mechanical, pneumatic, or hydraulic.

The most commonly used nonautomated mud tank fluid volume monitoring system is mechanical. It typically consists of a float located in a mud tank compartment (where gains and losses in total mud tank fluid volume can be detected) and a cable and pulley system connecting the float to a fluid level-monitoring indicator that can be read from the driller's position. An increase or decrease in tank volume causes the indicator to rise or fall according to the position of the float.

The nonautomated mud tank fluid volume monitoring system must meet the following requirements:

- The monitoring system must be capable of measuring a change of ± 2 m^3 (maximum) in total tank volume.
- The float for the monitoring system must be located in the appropriate mud tank compartment.
- The monitoring indicator must have readable and accurate increments.
- The driller must know the volume of fluid per increment.
- The monitoring indicator must be located near and readable from the driller's position.
- The driller must know the normal fluid level at all times in the mud tanks (as indicated by the fluid level-monitoring device).
- The float, cable assembly, and monitoring indicator must operate properly.

An automated fluid volume monitoring system is preferred for all well classes. However, if an automated system is used on wells in classes I to IV, it must meet all the requirements of an automated system.

8.2.2 Automated (Electronic) Mud Tank Fluid Volume Monitoring System

For well classes V and VI, critical sour wells and all wells drilled with oil-based drilling fluids, an automated mud tank fluid volume monitoring system that is electronically operated must be used.

An automated mud tank fluid volume monitoring system consists of a series of sensors located in each active compartment of the mud tank(s). These sensors indicate the mud level in each compartment and transmit the data continuously to an electronic monitoring station located at the driller's position. The system also includes an alarm to alert the driller to a preset increase or decrease in total tank volume.

The automated mud tank fluid volume system must meet the following requirements:

- The monitoring system must be equipped with mud tank fluid volume sensors in each active mud tank compartment.

- The monitoring system must provide accurate mud tank fluid volume readings that are being continuously reported on an electronic monitoring station.

- The electronic monitoring station must be readable from and located near the Driller's position.

  For critical sour wells, the electronic monitoring station must be equipped with chart recorders.

- The monitoring system must be capable of detecting a change of ±2 m^3 (maximum) in total tank volume.

  For critical sour wells, the monitoring system must be capable of detecting a change of ±1 m^3 in total tank volume.

- The monitoring system must be equipped with an alarm to alert the driller of a change of ±2 m^3 in total tank volume while drilling.

  For critical sour wells, a visual indicator must be installed (e.g., a highly visible flashing light) that will come on automatically whenever the alarm system is shut off.

- The driller must fully understand the system being used.

A flow line sensor is another monitoring device that can be used in conjunction with an automated mud tank volume monitoring system. The flow line flow sensor cannot be used alone as a monitoring device, but can be installed to augment the automated mud tank volume monitoring system.

8.2.3 Automated (Electronic) Mud Tank Fluid Volume Monitoring Systems—Surface Casing Reductions

For wells being drilled with reduced surface casing, additional monitoring requirements may apply. See Section 2.3 of *Guide 8: Surface Casing Depth Minimum Requirements*.

8.3 Trip Tank—Design and Fluid Level Monitoring

For all wells being drilled, a trip tank must be used.

The trip tank must

- be equipped with a fluid level-monitoring system that will accurately measure the volume of drilling fluid required to fill the hole while tripping the drill string from the well;
- be designed with both the suction and return lines connected to the trip tank when tripping the drill string into and from the well; and
- be equipped with a fluid level indicator that is visible from the driller's position in readable increments, and the driller must know the volume of fluid per increment for the system being used.

8.3.1 Well Classes I, II, and III

Where a trip tank is being used with a surface area less than 3.0 m^2:

- the trip tank must be designed such that a change in fluid level of 25 mm equals a fluid volume change of not more than 0.075 m^3—this equate to a maximum trip tank surface area of 3.0 m^2; and
- either a nonautomated or an automated fluid volume monitoring system may be used.

Where a trip tank is being used with a surface area greater than 3.0 m^2:

- an automated fluid volume monitoring system must be used—this system must be capable of showing volume changes of 0.04 m^3 or less.

8.3.2 Well Classes IV, V, and VI

Where a trip tank is being used with a surface area less than 6.0 m^2:

- the trip tank design must be such that a change in fluid level of 25 mm equals a volume change of not more than 0.15 m^3—this equates to a maximum trip tank surface area of 6.0 m^2; and
- either a nonautomated or an automated fluid volume monitoring system may be used.

Where a trip tank is being used with a surface area greater than 6.0 m^2:

- an automated fluid volume monitoring system must be used. This system must be capable of showing changes of 0.075 m^3 or less.

8.3.3 Critical Sour Wells

The trip tank design must be such that

- a change of fluid level of 25 mm equals a volume change of not more than 0.075 m^3—this equates to a maximum trip tank surface area of 3.0 m^2;
- the minimum usable trip tank volume must not be less than 3.0 m^3; and
- either a nonautomated or an automated fluid volume monitoring system may be used.

If a nonautomated fluid volume monitoring system is used:

- the volume increments on the monitoring board must not be greater than 0.1 m^3.

If an automated fluid volume monitoring system is used:

- the system must be capable of showing volume changes of 0.0375 m^3 or less and the monitoring system must have a minimum readout to two (2) decimal places.

9 Well-Site Supervision and Certification

9.1 Well-Site Supervision

For all wells being drilled, the licensee must provide the following:

- A qualified licensee's well-site representative (not the rig manager) who is responsible for the supervision of the drilling operations must be readily available (within two hours) at all times.

- A qualified rig manager who is responsible for the supervision of the drilling rig must be readily available (within two hours) at all times.

  Note that the licensee well-site representative and rig manager cannot supervise other drilling/servicing operations at the same time.

- For critical sour wells, prior to penetrating and during the drilling of the critical sour zone, there must be 24-hour on-site supervision. This requires a minimum of two well-site licensee representatives (not the rig manager) who must work no longer than a shift of 12 hours. The licensee's well-site representatives must be qualified and experienced in drilling sour wells.

9.1.1 Tripping and Well Control Situations

When potential hydrocarbon-bearing zones have been penetrated, either the licensee well-site representative or the rig manager must be on site while tripping in or out of the well. If it becomes necessary to make an unscheduled trip when neither of these individuals is present, the trip may commence immediately after contacting the licensee representative or rig manager. The individual(s) must then return to the well site immediately.

During well control situations, both of these individuals must be on site.

9.2 Blowout Prevention Certificates—Petroleum Industry Training Service (PITS)

The licensee's representative, rig manager, and driller must be trained and certified by PITS in the operation of blowout prevention equipment and well control.

9.2.1 First-Line Supervisor's Certificate

The driller must possess either a valid First-Line Supervisor's Blowout Prevention Certificate or a Second-Line Supervisor's Well Control Certificate issued by PITS.

Certificates expire on the date recorded on the certificate.

If the driller does not possess a valid PITS certificate, the drilling operations must be suspended (if safe to do so). Operations will not be allowed to resume until the driller is replaced with a qualified individual. The EUB may allow the rig manager to temporarily replace the driller and continue drilling operations (if safe to do so), providing that the replacement driller is en route (available within two hours).

9.2.2 Second-Line Supervisor's Well Control Certificate

The licensee's well-site representative and rig manager must possess a valid Second-Line Supervisor's Well Control Certificate issued by PITS.

Certificates expire on the date recorded on the certificate.

If any of the above individuals do not possess a valid PITS certificate, the drilling operations must be suspended (if safe to do so). Operations will not be allowed to resume until such persons are replaced with qualified individuals. The EUB may allow drilling operations to continue (if safe to do so), providing that the replacement individual(s) are en route (available within two hours).

10 Well Control, Crew Training, and Tripping

10.1 Well Control

At all times during the drilling of a well, the licensee must conduct operations and maintain control equipment and casing so that any oil, gas, or water encountered can be effectively controlled.

The licensee must ensure that sufficient drilling fluid density is maintained at all times to control formation pressures throughout the drilling of the well. The licensee must also ensure that all procedures, calculations, formulas, casing and tubular capacities and displacements, rig pump specifications, and current well data needed to control a kick at a well are available on location (see Appendix 10).

A kick is any unexpected entry of water, gas, oil, or other formation fluid into a wellbore that is under control and can be circulated out.

10.1.1 Maximum Allowable Casing Pressure (MACP)

The MACP is the maximum casing pressure that can be applied at surface without fracturing the formation at the casing shoe.

For well classes II – VI, the maximum allowable back pressure to be held at surface on the casing during a well control situation must be calculated for each casing setting depth and posted at the

- manifold shack, and
- remote choke control location (when a remote choke control is installed and/or required).

10.1.2 Reduced Speed Pump Pressure (RSPP)

The RSPP is a basic component in any well control event. The RSPP is the minimum amount of pump pressure required to overcome the mud circulation system's pressure losses needed to circulate the well at a reduced rate.

For well classes II – VI, when potential hydrocarbon-bearing zones have been penetrated, the reduced pump speed and the reduced pump pressure that will be used to circulate out a kick from the wellbore must be recorded in the drilling logbook at least once per tour.

10.1.3 Blowout Prevention and Well Control Procedures

Blowout prevention and well control procedures must be posted in the doghouse.

Procedures posted must, as a minimum, include

- flow check procedures,
- kick warning signs,
- crew positions during well control situations,

- well shut-in procedures, and
- well control methods.

Posting of the Blowout Prevention and Well Control Procedures chart issued by the Canadian Association of Oil Well Drilling Contractors (CAODC) is recommended.

10.1.4 STICK Diagram

A "STICK" diagram is a well data information sheet specific to the drilling operation of a well (obtained from researching offset well records). It must provide the appropriate on-site personnel (e.g., licensee, rig manager, driller) with sufficient well control information to drill the well and must be posted in the doghouse.

The STICK diagram must include, as a minimum, the following information:

- geological tops,
- anticipated formation pressures,
- mud weights required to control them,
- potential problem zones (e.g., lost circulation),
- abnormal pressured zones (e.g., reservoir pressure maintenance),
- potential H_2S zones, and
- other well occurrence information.

The appropriate on-site personnel must review and understand the information provided in the STICK diagram prior to spudding the well.

10.2 Crew Training

The rig crew must be trained in the operation of the BOP equipment and kick detection.

10.2.1 BOP Drills

BOP drills must be conducted a follows:

- The crew on tour must conduct a BOP drill
  - prior to commencement of drilling with a class I diverter system installed, and
  - before drilling out the surface, intermediate, or production casing shoe.
- Other crews must conduct BOP drills on their first tour after drill-out.
- Thereafter, BOP drills must be conducted every seven calendar days (if on the same well).
- For critical sour wells, all crews must conduct an additional BOP drill within the 24-hour period prior to penetration of the critical zone.

10.2.2 Crew Alert Method

An operable alert device must be installed for alerting the crew in the event of a well control situation or when conducting BOP drills.

10.2.3 Conducting Crew BOP Drills—Inspector's Involvement

The licensee's well-site representative and/or the rig manager should be requested to coordinate the BOP drill, following the procedures outlined in Appendix 11:

- A crew BOP drill should be conducted during the inspection if it is operationally prudent to do so.
- If adverse hole conditions will not permit a hands-on BOP drill, have the licensee's representative and/or rig manager conduct a verbal drill.
- The BOP drill conducted should determine the crew's ability to detect a well kick and perform a shut-in for the operation in progress at the time of the inspection.
- The crew must be capable of applying well control procedures in all drilling situations (e.g., drilling, tripping, out of the hole).

10.2.4 Crew Assessment and Procedures

The Crew Procedures Tables (Appendix 11) and the Crew Training Assessment Form (Appendix 12) may be used as a guide when observing drills.

If the crew is not properly trained, operations must be suspended until additional training is provided. The on-site supervisors should provide the necessary training.

10.2.5 Recording BOP Drills

All required BOP drills must be recorded in the drilling logbook.

10.3 Tripping

For all well classes, including critical sour, prior to tripping the drill string from the well:

- the drilling fluid density must be adequate to exert a sufficient trip margin that will ensure an overbalance of the expected formation pressures so that formation fluids do not enter the wellbore;
- a bottoms-up circulation must be conducted or a weighted tripping pill must be pumped.

For tripping requirements in the high-hazard area, see Section 14.

10.3.1 Flow Checks

For all well classes, including critical sour, when tripping the drill string out of the well, a 10-minute (minimum) flow check must be conducted and recorded in the drilling logbook at the following intervals:

- after pulling approximately the first 5 per cent of the drill string (measured depth) from the well;
- at approximately the midpoint depth (measured depth) of the well;
- prior to pulling the first stand of drill collars from the well; and
- after all of the drill string is pulled out of the well.

For all well classes, including critical sour, when tripping the drill string into the well, a **10-minute** (minimum) flow check must be conducted and recorded in the drilling logbook at the following intervals:

- upon reaching the surface casing shoe with the drill string; and
- at approximately the midpoint depth (measured depth) of the well.

Prior to conducting a flow check when tripping in or out of the well, the hole must be filled to surface.

10.3.2 Hole Filling

For all well classes (including critical sour), when tripping the drill string out of the well, the wellbore must be filled with drilling fluid at sufficient intervals so that the fluid level in the wellbore does not drop below a depth of **30 m** from surface.

See Appendix 13 for example calculations of the maximum length of pipe that can be pulled before the fluid level in the annulus drops 30 m.

10.3.3 Trip Records

For all well classes, when tripping the drill string out of the well:

- accurate records (date, location, depth, type of trip, etc.) must be kept of the theoretical and actual volumes of fluid required to fill the hole; and
- the trip records must be kept at the well site until the end of the drilling operation.

In addition to the above requirements, for critical sour wells:

- when tripping the drill string out of the well in the critical zone, the trip record(s) must be signed and dated by the licensee and the contractor representatives.

11 Electrical and Flame-Type Equipment

11.1 Electrical Appliances and Electrical Devices

Any electrical appliance or electrical device that is a potential source of ignition may not be used within 25 m of the wellbore without first shutting in the wellbore.

Any electric appliance or electrical device that is a potential source of ignition may not be used within 25 m of a separator, oil storage tank, or other source of ignitable vapour.

11.2 Electrical Motors and Electrical Generators

All electrical motors and electrical generators that are designed such that arcing is produced during operation must not be placed or operated within 25 m of a wellbore, separator, oil storage tank, or other source of ignitable vapour, unless the motor or generator is purged with an air intake located 25 m away from the above items.

11.3 Flame-Type Equipment

Flame-type equipment must not be placed or operated within 25 m

- of a wellbore without first shutting in the well;
- of a separator, oil storage tank, or other source of ignitable vapour.

Flame-type equipment is any fired heating equipment using an open flame. This includes a space heater, torch, heated process vessel, boiler, and an electric arc or open-flame welder, as well as well-site shacks and trailers with stoves, furnaces, and pilot lights, etc.

11.4 Incinerators and Burn Pits

Incinerators and burn pits must not be located within 50 m of a wellbore, separator, oil storage tank, or other source of ignitable vapour.

11.5 Smoking

No person is allowed to smoke within 25 m of a wellbore, separator, oil storage tank, other source(s) of ignitable vapour, or on a rig or derrick on a well site during the drilling operation.

Smoking restrictions are in effect from spud to rig release.

12 Casing Inspection

12.1 30-Day Casing Inspection

Surface and intermediate casing exposed to wear by pipe movement or a combination of rotation/movement must be tested a minimum of every 30 days to determine the integrity of the casing.

12.2 Casing Integrity

12.2.1 Test Methods

There are two acceptable methods for determining casing integrity:

- A pressure test may be conducted on the casing, or
- a casing integrity inspection log may be run.

12.2.2 Casing Integrity—Pressure Testing

If the licensee elects to pressure test, the surface/intermediate casing must be pressure tested as follows:

- **Surface Casing**—If only surface casing is set, the minimum pressure test required at surface (in kPa) is 2.5 times the licensed true vertical depth (TVD) of the well or drilled depth (TVD) if greater.

If an intermediate casing string will be set, the minimum pressure test required at surface (in kPa) is 2.5 times the intermediate casing setting depth (TVD).

Surface Casing Pressure Test Example

Well Data

Licensed well depth (TVD) = 3500 m
Surface casing depth = 450 m

2.5 times the licensed well depth (TVD) = 2.5 x 3500
= 8750 kPa

- **Intermediate Casing**—If intermediate casing is set, the minimum pressure test required at surface is 50 per cent of the BHP of the well. If the actual BHP is unknown or not well defined in the area, a gradient of 11 kPa/m may be used for calculating a theoretical BHP (i.e., BHP = 11 kPa/m times licensed well depth [TVD], or drilled depth [TVD] if greater).

The required test pressure must not be reduced by the hydrostatic pressure created by the fluid column in the wellbore, as an opposing pressure exists on the outside of the casing because of the cement, formation pressures, or hydrostatic head of the wellbore fluids.

Intermediate Casing Pressure Test Example

Well Data - BHP (known)

Licensed well depth (TVD) = 3500 m
Intermediate casing setting depth = 3000 m
Test pressure = TP
BHP = 35 000 kPa

$$TP = 50\% \times BHP$$

$$TP = \frac{50}{100} \times BHP$$

$$TP = \frac{50}{100} \times 35\,000 \text{ kPa}$$

$$TP = 17\,500 \text{ kPa}$$

Well Data - BHP (unknown)

Licensed well depth (TVD) = 3500 m
Intermediate casing setting depth = 3000 m
Test pressure = TP

$$TP = 50\,\% \times (11 \text{ kPa} \times \text{licensed well depth})$$

$$TP = \frac{50}{100} \times (11 \text{ kPa} \times \text{licensed well depth})$$

$$TP = \frac{50}{100} \times (11 \text{ kPa} \times 3500)$$

$$TP = 19\,250 \text{ kPa}$$

12.2.3 Logging the Casing

If the licensee elects to log the casing, the surface/intermediate casing must be logged using a log or a combination of logs, fully interpreted on a joint-by-joint basis, which

- determines the percentage (%) penetration of anomalies,
- distinguishes between internal and external corrosion, and
- detects holes, pits, perforations, metal loss, and metal thickness.

When a casing inspection log is used to assess the casing integrity and condition, the maximum burst resistance, based on the least wall thickness and minimum yield strength of the casing, must be greater than or equal to 0.5 times the formation pressure. The following equation must be satisfied:

$$P_y = 0.875 \frac{2Y_p t}{D} \geq 0.5 \text{ formation pressure}$$

P_y = minimum internal yield (kPa)
Y_p = specified minimum yield strength (kPa)
t = nominal wall thickness or reduced wall thickness (mm)
D = nominal outside diameter (mm)
0.875 = the reduction factor allowing for minimal wall thickness (API wall thickness tolerance of 12.5 per cent)

If a licensee elects to conduct a pressure test after running a casing inspection log, the results of the pressure test will be overriding. Therefore, if a log shows that casing wear is greater than that which is considered acceptable, but the pressure test is satisfactory, then the EUB would consider the casing as satisfactory.

13 Drillstem/Well Testing

13.1 Drillstem Testing (DST)

Before commencement of any DST, licensees must review and meet the requirements of the current edition of EUB *Guide 60: Upstream Petroleum Industry Flaring Guide*. In addition, when conducting a DST, the following minimum requirements must also be met:

- A reverse-circulating sub must be installed in the drill string.
- A remote-controlled master valve must be installed on the testing head.
- A separate DST line(s) must be installed for testing purposes, and the end of the line(s) must terminate at least 50 m from the well.
- The DST line(s) must be secured at 10 m intervals. Stakes or weights must be used (as dictated by the soil conditions).
- The DST manifold must have (as a minimum) the same pressure rating as the required BOP system.
- The DST manifold must be secured to restrict it from movement.
- If liquids are produced during a DST, the liquids must be separated.
- Liquids produced during a DST must not be directed to an earthen pit.

Drillstem testing is not permitted on critical sour wells.

For additional information on drillstem testing, see *IRP 4: Well Testing and Fluid Handling*, Section 4.1.

14 High-Hazard Area and Surface Casing Reductions

14.1 High-Hazard Area—Southeastern Alberta

Due to the high frequency of serious well control incidents within townships 19 to 24, ranges 5 to 10, west of the 4th meridian (see Figure 3), additional well control requirements apply to all wells being drilled in this area to the Mannville Group or deeper.

14.1.1 Surface Casing

The surface casing must be set at a depth of no less than 180 m.

14.1.2 Drilling Fluid Density

After penetration of the Mannville Group and prior to tripping the drill string out of the hole, the drilling fluid density must be adequate to exert a minimum of 1400 kPa overbalance of the Mannville Group's expected pressure.

14.1.3 Emergency Flare Line

In the high hazard area, an emergency flare must be installed. The emergency flare line consists of two flanged valves and a flare line that is connected to the drilling spool and extends out to a flare pit or flare tank (see Figure 4).

- The emergency flare line must have a working pressure equal to or greater than the required BOP stack.
- The emergency flare line must be a minimum 76.2 mm diameter throughout.
- The emergency flare line valves must be flanged together and connected directly to the drilling spool (piping extensions or fluid turns are not permitted between the drilling spool and the two valves).
- The emergency flare line valves must be operable with the valve handles installed at all times.
- The flare line connection to the two valves must be flanged. All connections downstream of this flanged connection must be flanged, hammer union, or threaded.
- The emergency flare line must be properly made up and connected at all times.
- The emergency flare line may contain direction changes provided they are made with right-angle (90°) connections and constructed of tees and crosses blocked on fluid turns. (Fluid turns such as elbows, tees, etc., are not permitted at the end of the flare line to direct wellbore effluent into a flare pit.)
- Directional changes in the emergency flare line(s) can also be made using flexible hose provided the hose meets the requirements set out in Section 3.2: Flare and Emergency Flare Line(s).

- The emergency flare line must be adequately secured at 10 m intervals, and the end of the line must be secured as close as possible to the flare pit. Stakes or weights must be used as dictated by the soil conditions. Stakes used in sandy or loose soil conditions are not acceptable.
- The emergency flare line must be either self-draining or have some means incorporated to ensure that fluid can be drained from the line during winter operations. Precautions must be taken to minimize environmental impact from spillage.
- The end of the emergency flare line must terminate at least 50 m from the well in a flare pit or flare tank.
- Prior to assembly, all connections in the emergency flare line must be visually inspected. After assembly of the connections, an inspection must be conducted to ensure that the line has been properly connected. The results of the inspections must be recorded in the drilling logbook.

The emergency flare line should be laid in a straight line. However, a slight curvature of the line is acceptable.

14.2 Surface Casing Reductions

Surface casing reductions are available for low-risk wells in a development-type setting. Where surface casing reductions have been implemented, additional well control requirements must be met. Specifically, where **Type 3** and **Type 4** surface casing reductions (see *Guide 8,* Section 2) have been applied, an emergency flare line must be installed.

14.2.1 Emergency Flare Line

The emergency flare line must meet the minimum requirements as outlined in Section 14.1.3 above.

14.3 High-Hazard Area/Surface Casing Reductions—Well Control Equipment

BOP pressure rating, accumulators, manifold requirements, etc., for wells drilled in the high-hazard area and for surface casing reductions depend on well class (see Appendix 3).

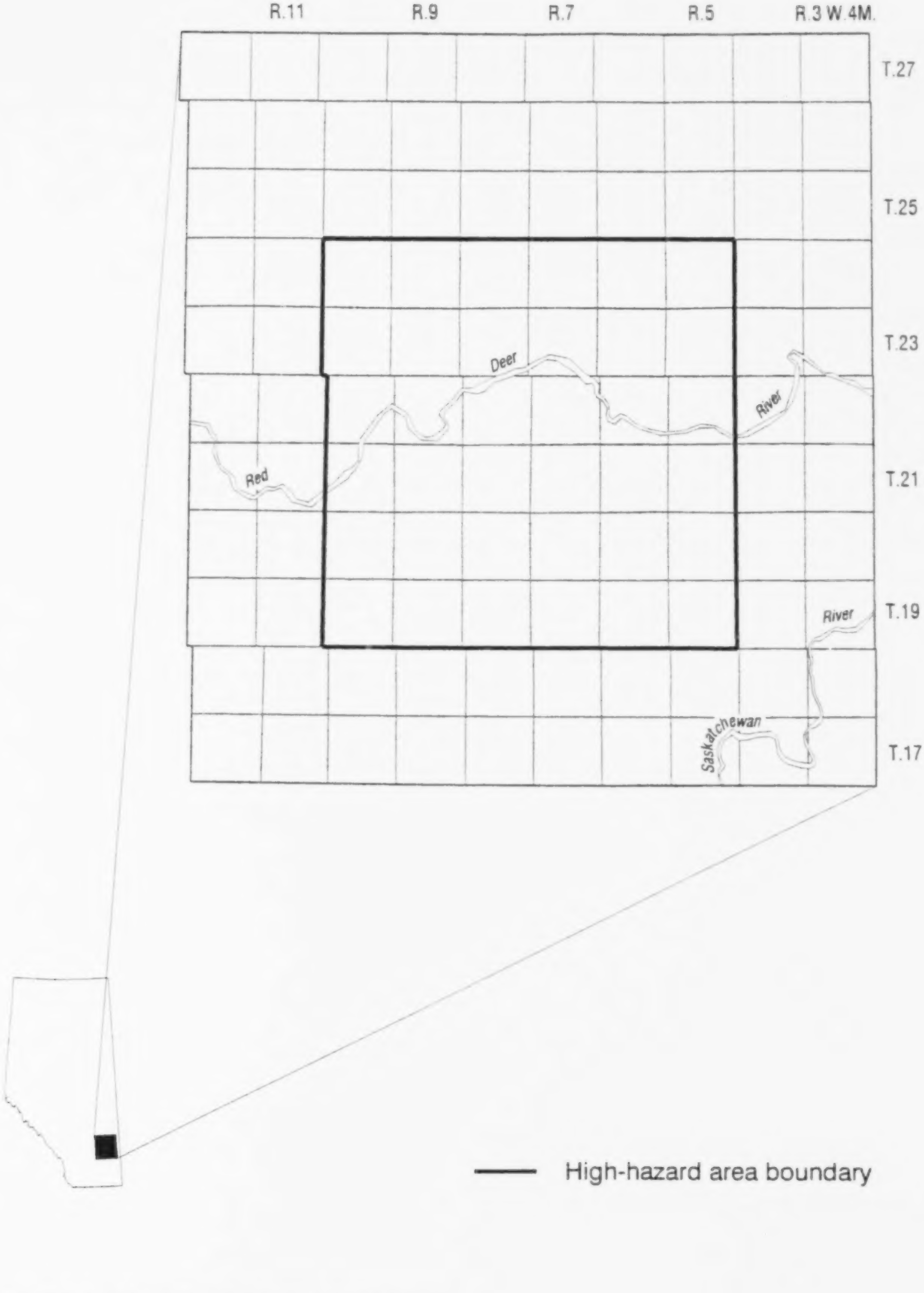
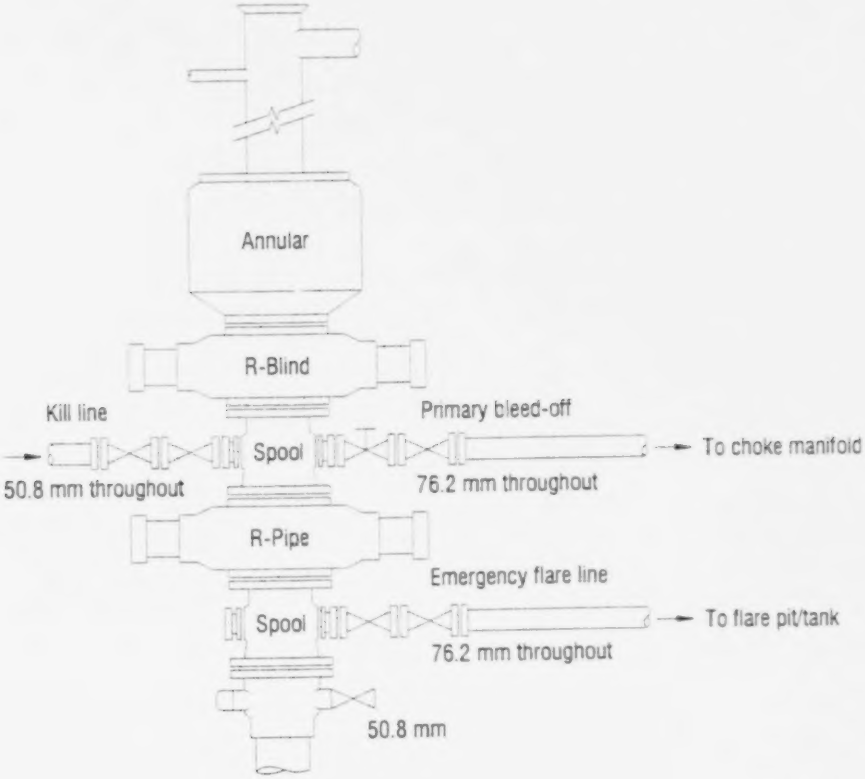

R.11
R.9
R.7
R.5
R.3 W.4M.
T.27
T.25
T.23
T.21
T.19
T.17
Red
Deer
River
River
Saskatchewan
High-hazard area boundary

Figure 3. High-hazard area for southern Alberta


Annular
R-Blind
Kill line
Primary bleed-off
Spool
To choke manifold
50.8 mm throughout
76.2 mm throughout
R-Pipe
Emergency flare line
Spool
To flare pit/tank
76.2 mm throughout
50.8 mm

Note:

1. A flanged outlet on the lower ram preventer may be substituted in place of the lower drilling spool.
2. See Appendix 2 for equipment symbols.

Figure 4. Emergency flare line configuration for high-hazard area (southeastern Alberta) and for type 3 and type 4 surface casing reductions

15 Sour and Critical Sour Wells

15.1 General Information

This section details additional requirements that the licensee must meet when drilling sour and critical sour wells.

For additional information, see *ID 97-6* and *Industry Recommended Practices for Drilling Critical Sour Wells (IRP*, Volume 1).

15.2 Emergency Response Plan (ERP)

Where an approved specific ERP is required:

- The ERP must be on location prior to spud and throughout the drilling operation.
- The licensee must conduct a review of its ERP, involving on-site personnel required to implement the plan, within 96 hours prior to conducting operations in the sour zone.
- The licensee's representative must be familiar with the ERP.
- All equipment specified in the ERP must be available prior to entering the critical or sour zone.

When conducting an inspection on a critical sour well, the EUB inspector must complete a Field Inspection Branch ERP Review form (see Appendix 15).

For more information regarding emergency response planning, see EUB *Guide 71: Emergency Preparedness and Response Requirements for the Upstream Petroleum Industry*.

15.2.1 Communicating with Parties (Residents, Registered Trappers, Industrial Operators, etc.) within the EPZ

The licensee must notify all parties within the EPZ

- 48 hours prior to entering the sour zone, and
- after all drilling operations have been completed (rig release).

For critical sour wells with residents within the EPZ, the EUB inspector must conduct a minimum of two resident contacts and complete the Public Contact Form (see Appendix 16).

15.3 Warning Sign in H_2S Area

An H_2S warning sign must be posted at the well site prior to penetrating any potential H_2S-bearing formation.

The sign must be removed or covered if no H_2S is anticipated.

15.4 Critical Sour Well

15.4.1 Drilling Plan

A copy of the approved drilling plan must be on site prior to spud and throughout the drilling operation.

15.4.2 Intermediate Casing

Intermediate casing must be set to an appropriate point above the first critical sour zone or at a point before the cumulative release rate becomes critical.

If an exemption for setting intermediate casing has been approved by the EUB, a copy of the approval must be on location.

15.4.3 BOP System and Choke Manifold

The BOP stack configuration must conform to one of the three BOP configurations shown in Figure 5. If BOP Configuration 2 or BOP Configuration 3 is used, an appropriately sized ram blanking tool that fits into the top pipe ram must be on location and readily available. This allows the top pipe ram to perform the function of a blind ram when the drill string is out of the hole. In addition, if BOP Configuration 3 is used, there must be sufficient surface or intermediate casing to contain the maximum anticipated reservoir pressure.

The choke manifold must conform to the minimum choke manifold design (valves, chokes, piping, etc.) as shown in Figure 6. In addition, the remote hydraulically operated choke (on the primary manifold wing) must be a nonrubber sleeved choke. See Section 2.1.2.2 for additional choke manifold requirements.

15.4.4 Shear Blind Rams

Shear blind rams must be used for all critical sour wells if

- the calculated EPZ size intersects the boundaries of an urban centre, or
- the calculated EPZ encompasses more than 100 occupied dwellings.

If the licensee has received a shear blind rams waiver from the EUB Well Operations Group, a copy of the waiver must be on location.

15.4.5 Drill Pipe

Drill pipe used in critical sour wells must be premium class or better grade drill pipe.

The EUB Operations Group in Calgary must be notified immediately of any drill string failures.

15.4.6 Indicators and Recording Devices

Indicators must be installed and operational for measuring

- pump pressure, pump strokes per minute, hook load, and table torque.

All such indicators must be visible from the driller's position.

A continuous recording device is also required to record

- the rate of penetration, pump pressure, pump strokes per minute, hook load, rotary table revolutions per minute (rpm), and table torque.

This record must be kept for the entire drilling operation and be made available for inspection at the well site.

15.4.7 H_2S Monitoring

When drilling in the critical zone, the following monitoring requirements must be met:

- When water-based drilling fluid is in use, a continuous pH monitoring system must be installed as close as possible to the flow line discharge and be equipped with an alarm to signal a drop in pH. The pH must be maintained at 10.5 or greater.

- Ambient H_2S detection is required and must consist of a continuous H_2S detection monitoring system that activates audible and visual alarms near the driller's position when sensing ambient air H_2S concentrations of 10 parts per million (ppm) or greater. The system must consist of at least one sensor located at the shale shaker. Additional sensors may be placed at other locations, such as the bell nipple, rig floor, and mud-mixing unit. Sensors must be able to detect H_2S concentrations of 5 ppm and greater. Qualified personnel must be on site to test and provide maintenance to this instrumentation.

At least one portable ambient H_2S concentration detection device must be on location.

15.4.8 Sulphide Monitoring

While drilling in the critical sour zone with water-based drilling fluid, the following sulphide monitoring requirements must be met:

- Sulphide content must be monitored by either a continuous sulphide monitor or by hourly HACH tests.

  If soluble sulphides are detected, a Garret Gas Train Test (GGTT) must be conducted on the filtrate every two hours and the appropriate amount of H_2S scavenger must be added to that ensure that there are no soluble sulphides in the filtrate. When no soluble sulphides are detected in the filtrate, the licensee may revert back to continuous sulphide monitoring or hourly HACH tests.

- A record of the sulphide content in the mud must be maintained throughout the drilling of the critical sour zone.

While drilling in the critical sour zone with oil-based drilling fluid, the following sulphide monitoring requirements must be met:

- Oil-based drilling fluids must be tested using a modified GGTT a minimum of three times per day on the whole drilling fluid.

  If soluble sulphides are detected in the whole oil-based mud by the modified GGTT, the frequency of the modified GGTT must be increased to every two hours and the appropriate amount of H_2S scavenger must be added to ensure that there are no soluble sulphides in the whole oil-based mud. When no soluble sulphides are detected in the whole oil-based mud, the licensee may revert back to the modified GGTT three times per day.

- A record of the sulphide content in the mud must be maintained throughout the drilling of the critical sour zone.

15.4.9 Testing and Coring

Critical sour zones must not be drillstem tested.

Coring is permitted on critical sour wells. However, if the well is located in an exploratory/nondevelopment setting, the porosity of the critical zone must be penetrated prior to tripping out for the coring assembly to ensure normal pressures, or if upper porous interface must be cored, the ability to circulate above the core barrel must be available (e.g., ported string).

15.4.10 Underbalanced Drilling

Equipment requirements will change significantly on a critical sour well to be drilled underbalanced. In these cases, the requirements of EUB *ID 94-3: Underbalanced Drilling* must also be met.

The EUB will not approve critical sour underbalanced drilling operations that have residents inside the calculated EPZs until the regulatory requirements for these types of wells have been reviewed and assessed and the findings published.

15.4.11 Personnel

The licensee and contractor representatives must have current PITS H_2S Alive certification and experience in drilling critical sour wells.

A minimum five-man drilling crew must be maintained and all crew members must have PITS H_2S Alive certification.

On-site service personnel (mud-men, loggers, geologists, etc.), must have previous experience in sour well drilling operations and be trained in H_2S safety.

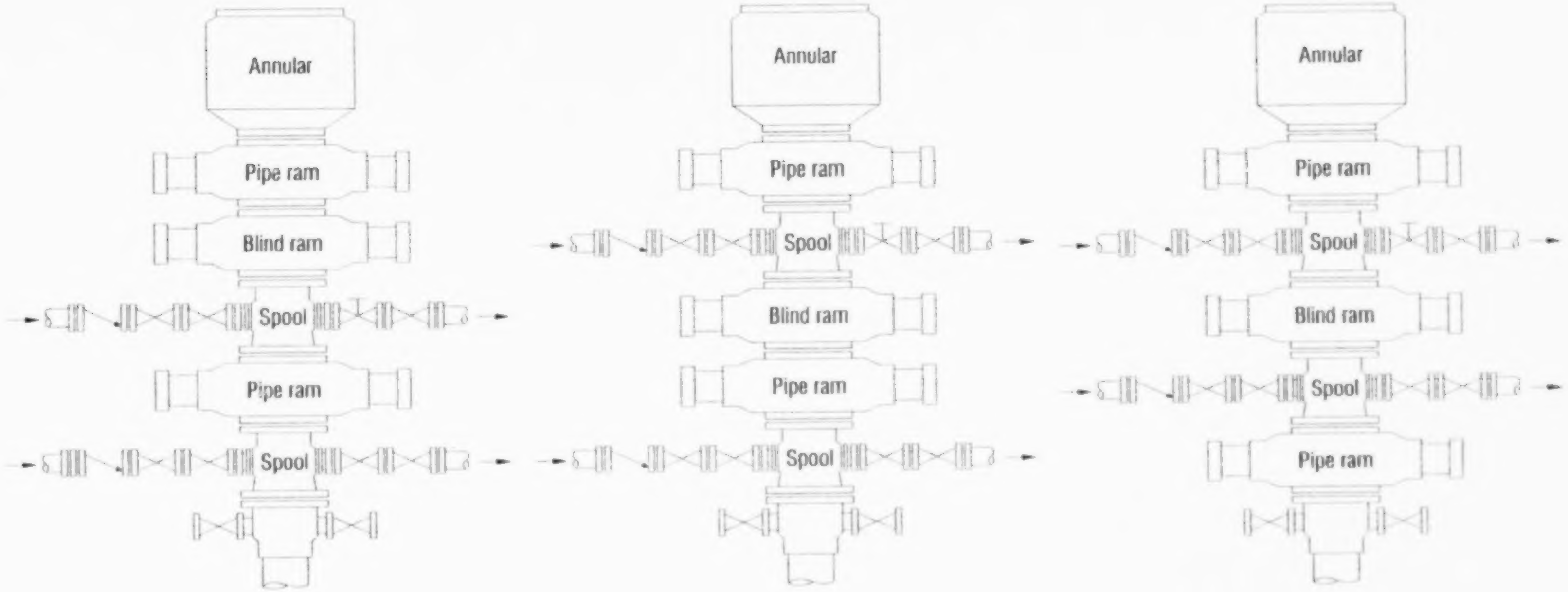
During the critical period of the drilling operation, safety personnel and adequate safety equipment for all workers must be on site. (Minimum requirements are specified by the Workplace Health and Safety [WPH&S] Legislation.)

See Section 9 for additional supervision and personnel requirements.

15.4.12 Ignition Criteria

The licensee must have clear and specific plans in place to ignite an uncontrolled flow. All critical sour wells must have a primary and a backup well ignition system during the drilling of the critical zone. The primary ignition system must be installed such that activation can be achieved from a safe location through a time-delayed triggering device that will allow for complete egress of all personal from the well site prior to ignition taking place. The backup system may be a manual system (e.g., a flare gun).

For more information on ignition criteria, see EUB *Guide 71: Emergency Preparedness and Response Requirements for the Upstream Petroleum Industry*.


Annular
Pipe ram
Blind ram
Spool
Pipe ram
Spool
Annular
Pipe ram
Spool
Blind ram
Pipe ram
Spool
Annular
Pipe ram
Spool
Blind ram
Spool
Pipe ram

CONFIGURATION 1
(preferred)

CONFIGURATION 2

CONFIGURATION 3

Note:

1. Hydraulic and manual valve positions in bleed-off line are interchangeable.
2. For wells projected to depths less than 1800 m, a flanged outlet on the lower ram preventer may be substituted in place of the lower drilling spool.
3. If BOP Configuration 2 or BOP Configuration 3 is used, an appropriately sized ram blanking tool that fits into the top pipe ram must be on location and readily available.
4. If BOP Configuration 3 is used, there must be sufficient surface or intermediate casing to contain the maximum anticipated reservoir pressure.
5. Shear blind rams may be required in place of the blind rams (see Section 15.4.4).
6. See Appendix 2 for equipment symbols.

Figure 5. BOP stack configurations—critical sour wells

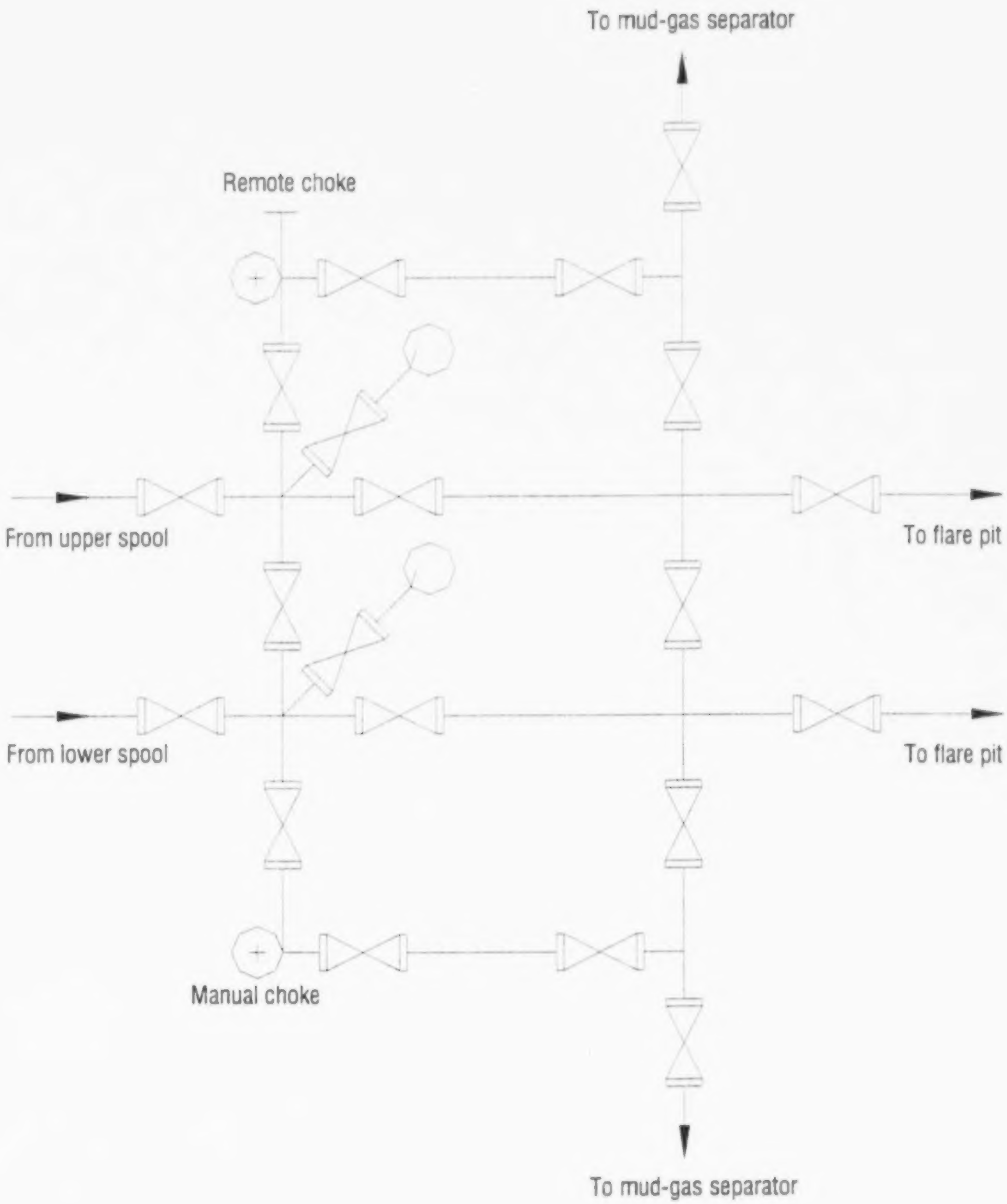

To mud-gas separator
Remote choke
From upper spool
To flare pit
From lower spool
To flare pit
Manual choke
To mud-gas separator

Figure 6. Choke manifold—critical sour wells

16 Well-Site Records and Reporting

16.1 Notification of Commencement of Drilling (Spud)

Upon the commencement of the drilling of a well, the licensee must notify the EUB Field Surveillance Branch within 12 hours.

16.2 Drilling and Completion Data Recording

When a well is in the process of being drilled, completed, reconditioned, or abandoned, the licensee must keep a daily record (drilling logbook) of operations performed at the well site.

The daily report must include complete data on all operations performed during the day. This includes drilling, surveying, logging, testing, running casing, cementing, fishing, perforating, acidizing, fracing, abandonment operations, etc. Suspension of any operations must also be noted on the current daily report.

The minimum information that the daily report must contain is outlined in EUB *Guide 59: Well Drilling and Completion Data Filing Requirements*, Appendix 4.

16.3 Loss of Circulation, Kicks, Blows, and Blowouts

At all times during which a well is being drilled, tested, completed, or reconditioned, the licensee must conduct operations and maintain control equipment and casing so that any oil, gas, or water encountered is effectively controlled.

If a loss of circulation, kick, blow, or blowout occurs during the drilling operation, it is the responsibility of the licensee to report the event to the EUB.

16.3.1 Loss of Circulation—Recording and Reporting

Loss of circulation occurs when drilling fluids flow from the wellbore into the formation.

In the event of a loss of circulation, the licensee must

- record loss of circulation information and remedial actions taken to control the loss of circulation in the drilling logbook, and
- advise the appropriate EUB Field Centre immediately (only if the well requires an EUB-approved ERP).

16.3.2 Kick—Recording and Reporting

A kick is any unexpected entry of water, gas, oil, or other formation fluid into a wellbore that is under control and can be circulated out.

In the event of a kick, the licensee must

- record kick information and remedial actions taken to control the kick in the drilling logbook, and
- advise the appropriate EUB Field Centre immediately (only if the well requires an EUB-approved ERP).

16.3.3 Blow—Recording and Reporting

A blow is the unexpected release of wellbore fluids (gas, oil, water, mud) to the atmosphere. The flow can be controlled almost immediately by shutting the well in using wellhead valves or blowout prevention equipment or by directing the flow to the bleed-off system until the well is killed.

In the event of a well blow, the licensee must

- record blow information and remedial actions taken to control the blow in the drilling logbook, and
- advise the appropriate EUB Field Centre immediately.

16.3.4 Blowout—Recording and Reporting

A blowout is the complete loss of control of the flow of fluids (gas, oil water, mud) from a well to the atmosphere or the flow of fluids from one underground reservoir to another. Control can only be regained by killing the well, installing or replacing equipment to permit shut-in, or drilling a relief well.

In the event of a well blowout, the licensee must

- record blowout information and remedial actions taken to control the blowout in the drilling logbook, and
- advise the appropriate EUB Field Centre immediately.

16.4 Deviation Surveys

The licensee must run deviation surveys at depth intervals not exceeding 150 m.

A record of surveys must be made available to the EUB upon request.

16.5 Directional Surveys—Critical Sour Wells

For critical sour wells, a deviation survey must be run at depth intervals not exceeding 150 m. However, just prior to entering the critical zone, a directional survey (azimuth and inclination) is required. After penetration of the critical zone, directional surveys (azimuth and inclination) must be conducted at maximum intervals of 150 m when the wellbore has an inclination less than 3°. If the inclination is greater than 3°, a directional survey must be conducted at maximum intervals of 60 m.

A record of the surveys must be made available to the EUB upon request.

16.6 Well Licence Posting

For wells being drilled, the licensee must possess a valid well licence issued by the EUB in accordance with *Guide 56: Energy Development Application Guide*.

A duplicate of the valid well licence must be posted and kept prominently displayed at the well site during the drilling operations.

17 Licensee and Contractor Inspections

17.1 Daily Inspections

For all wells being drilled, the licensee and contractor representatives must conduct a daily walk-around inspection of the rig to identify any rig deficiencies. These inspections should be carried out in conjunction with the daily function testing of the BOP equipment.

17.1.1 Recording Inspections

The licensee and the contractor representatives must record the daily inspections in the drilling logbook.

17.2 Detailed Inspections

The licensee and the contractor representatives must conduct a detailed inspection of the rig and complete a detailed inspection form. A detailed inspection form is a comprehensive check sheet that must (as a minimum) include all items listed in Appendix 1.

For wells without surface casing set (class I wells or wells that require a diverter system), detailed rig inspections must be conducted

- prior to commencement of the drilling operation, and
- at least once every 7 days thereafter during the drilling of the well.

For well classes II to VI, detailed rig inspections must be conducted

- prior to drilling out the surface casing, and
- at least once every 7 days thereafter during the drilling of the well.

For critical sour wells, detailed rig inspections must be conducted

- prior to drilling out the surface casing shoe and weekly thereafter;
- prior to drilling out the intermediate casing shoe and weekly thereafter; and
- within the 24-hour period prior to penetrating the critical zone. (If intermediate casing is set immediately above the critical zone, this coincides with the above.)

For critical sour wells, the licensee must notify the appropriate EUB Field Centre at least 48 hours prior to the detailed inspections being initiated.

17.2.1 Recording Inspections

The licensee and the contractor representatives must record detailed inspections in the drilling logbook.

Entering and initialling a comment such as: "Detailed inspection completed" in the drilling logbook or initialling the applicable section of the drilling logbook is appropriate.

18 Well-Site Fluids and Environment

18.1 Invert Mud Systems

The use of oil-based fluids for drilling mud must be considered potentially hazardous.

When oil-based fluids are used:

- the on-site safety of this procedure must be addressed before commencing operations;
- make-up reserve for hydrocarbon-based drilling fluid must be stored a minimum of 25 m from the well and 50 m from a flare pit/tank, incinerator, or burn pit.

Due to the potentially hazardous nature of oil-based drilling fluids and the additional complications (e.g., gas solubility in oil-based fluids) that may occur in a well control event, it is recommended that the licensee review control procedures with the rig crews prior to penetrating hydrocarbon-bearing zones.

For further, more detailed information on oil-based drilling fluids, see *Industry Recommended Practice (IRP), Volume 14: Non Water Based Drilling and Completions Fluids*. Also see Section 8.2.2 in this guide for additional requirements.

18.2 Crude Oil Used to Release Stuck Drill String (Spotting)

The use of crude oil to release stuck drill string (spotting) must be considered potentially hazardous.

When crude oil is used for spotting:

- the on-site safety of this procedure must be addressed before commencing operations, and
- the crude oil must be dead oil and contain no H_2S.

18.3 Oil Storage Tanks

Oil storage tank(s) (e.g., for oil recovered during a drillstem test) must not be located within 50 m of the wellbore, flare pit/tank, incinerator or burn pit.

18.4 Temporary Aboveground Storage Tank Diking Requirements

Temporary aboveground storage of fluids produced or stored during drilling, completions, well testing, or servicing operations do not require diking if

- the site is manned for the duration that fluids are being produced into the tank, or
- the tank is fitted with a high-level shutdown device to prevent overflowing, or
- the tank is used only for storage (i.e., produced fluids are not directed to the tank).

If a temporary aboveground storage tank is used and not diked for well drilling, completions, well testing, or servicing operations and the fluids are just being stored, the licensee must

- empty the tank contents within 72 hours of completing the drilling operation.

For additional requirements on temporary storage, see EUB *Guide 55: Storage Requirements for the Upstream Petroleum Industry*.

18.5 Sump Construction

The Canadian Association of Petroleum Producers (CAPP) issued "Environmental Operating Guidelines" for the petroleum industry in May 1999. Along with many other recommendations, this document suggested that the following guidelines be recognized during sump construction and operation.

- The sump should be excavated from impervious, undisturbed subsoil and should be shaped to allow maximum reuse of clear water for mud make-up.
- The sump must be adequately sized to allow for the anticipated volume of drilling fluid. (Although certain drilling variables may be expected, 1 m of freeboard is considered acceptable.)
- The sump should be located on the high side of the lease and as far away as possible from any bodies of water.
- Rain and snow runoff diversion ditches may be necessary if the topography poses a problem or if the area is considered sensitive.
- Sumps constructed in permeable soil must be sealed with clay, a synthetic liner, or any other approved technique that will prevent fluid leakage.

18.6 Drilling Fluid Disposal

For drilling fluid disposal requirements, see EUB *Guide 50: Drilling Waste Management*.

18.7 Containment of Fluids and Spills

The licensee is responsible for the immediate containment and cleanup of all unrefined (oil, salt water, etc.) and refined (diesel, gasoline, chemicals, mud additives, etc.) fluid spills on or off lease.

The licensee must ensure that

- all fluids used or generated during the drilling operation are properly contained;
- appropriate corrective action is initiated immediately if sump fluid, mud additives, chemicals, fuel, or any other materials have been spilled on or off lease;
- any unrefined spill off lease or any unrefined spill in excess of 2 m^3 on lease is reported immediately to the appropriate EUB Field Centre;

- the landowner is advised of any unrefined spill off lease or any unrefined spill in excess of 2 m^3 on lease, and the licensee must adequately address all concerns;

- all contaminated spill material is handled and disposed of in accordance with EUB *Guide 58: Oilfield Waste Management Requirements for the Upstream Petroleum Industry*.

18.8 Noise Emissions

All noise levels generated from the drilling operation must meet the requirements of EUB *Guide 38: Noise Control Directive User Guide* and *ID 99-8: Noise Control Directive*.

18.9 Odourous Emissions

Any odourous emissions resulting from the drilling operation that could be hazardous and/or a nuisance to the public must be identified and controlled so that the odours do not migrate off lease.

18.10 Waste Management

It is the responsibility of the licensee to ensure that all waste generated and stored at the well site is managed in accordance with *Guide 58*.

18.10.1 Characterization

The licensee is responsible for proper characterization of all wastes generated or stored during the drilling operation. The waste characterization is then used in assessing the appropriate handling, treatment, and disposal of the waste.

The two major categories under which oilfield wastes may be characterized are

- dangerous oilfield wastes, and

- nondangerous oilfield wastes.

As a minimum, the following information must be readily available to show proper waste characterization:

- the type of wastes,

- the characteristics of wastes, dangerous or nondangerous, and

- the volume of wastes currently generated and stored on site.

18.10.2 Storage

All waste storage containers on site must be designed to

- contain the wastes and prevent any odour problems associated with the waste,

- prevent spills when loading or unloading waste materials, and

- ensure segregation of each waste generated or stored on site (dangerous and nondangerous).

All waste must be removed after the completion of drilling operations.

As a minimum, the following information must be readily available to show proper storage and handling of oilfield wastes:

- a list of all wastes generated, and
- the volume of wastes stored.

18.10.3 Disposal

The licensee is responsible for the disposition of all wastes stored and generated on site during the drilling operation.

As a minimum, the following information must be readily available:

- the disposal plans in place for all waste stored and generated on site.

18.10.3.1 Accounting and Documentation

The licensee is responsible for the accounting and documentation of oilfield wastes generated, stored, and disposed of from the drilling operation from its source to its final destination.

The following minimum documentation is required:

- records showing the source, volume, and final disposition of wastes generated on site.

For further, more detailed information on waste characterization, storage, disposal, accounting, and documentation, see *Guide 58*.

19 Underbalanced Drilling

The requirements for underbalanced drilling are currently under review. See *ID 94-3: Underbalanced Drilling* for the current requirements.

If the requirements set out in *ID 94-3* differ from those in this guide, the requirements in this guide take precedence.

The EUB will not approve sour underbalanced drilling operations that have residents inside the calculated EPZs until the regulatory requirements for these types of wells have been reviewed and assessed and the findings published.

Deficiencies for underbalanced drilling operations will be categorized according to the criteria set out in *IL 99-4: EUB Field Surveillance Enforcement Process and Ladder.*

20 Oil Sands Core Holes and Evaluation Wells

This section sets out the EUB's minimum requirements with respect to surface casing and blowout prevention practices, as well as equipment for drilling oil sands core holes and oil sands evaluation wells not deeper than 200 m within the Surface Mineable Areas (see Figure 7).

For wells deeper than 200 m within the Surface Mineable Areas, all the requirements set out in EUB *Guide 36: Drilling Rig Inspection Manual* must be complied with.

20.1 Surface Mineable Areas

For wells not deeper than 200 m and inside the Surface Mineable Areas, the licensee must meet the following minimum requirements:

- Conductor pipe must be set into a competent formation.
- A system to divert gas (e.g., pack-off, rotating head, diverter) and a diverter line must be installed.
- During cold weather operation, sufficient heat must be provided to ensure proper operation of the diverter system.
- The diverter system must be mechanically tested daily.
- The diverter line must terminate a minimum of 15 m away from the wellbore.
- The diverter line must be adequately secured. Stakes or weights must be used, as dictated by the soil conditions.
- The mud tank or pit must be located a minimum of 2 m from the wellbore and outside any enclosure around the wellbore.
- The drilling rig must be equipped with a stabbing valve or similar device to prevent flow up the inside of the drill string.
- The stabbing valve must be stored in the open position.
- The stabbing valve and associated tools must be operable and readily accessible (on the rig floor or in the doghouse).
- The drilling rig must be equipped with the necessary cross-over subs, which enable the make-up of the stabbing valve with the drill pipe, drill collars, or any other tubulars in the well.
- Wire line coring operations inside the drill pipe must be conducted with equipment adequate to shut off any flow through the inside of the drill string.
- When retrieving core or pulling pipe, the hole must be kept full of drilling mud at all times.

- All engines operating within 15 m of the well must be equipped with engine shutoff devices:
    - air shutoffs for diesel engines, or
    - electric shutoffs for gasoline (includes propane powered) engines.

- All enclosed areas, such as core shacks, doghouses, etc., located within 15 m of the wellbore must have two doors. These doors must open out from the wellbore.

- All open fires, flame-type equipment, or other sources of ignition must be located a minimum of 15 m from the wellbore.

- Winter shrouding surrounding the wellbore must be left open at the top and bottom to prevent the accumulation of hazardous vapours.

- The rig crew must be trained in the operation of the diverter system.

- At least one person who has a valid PITS Second-Line Supervisor's Certificate in well control procedures must be readily available.

- A daily record of operations performed at the well site must be kept.

Oil sands core hole and oil sands evaluation wells drilled within an approved mine area (approved mine area refers to the actual mine lease within the surface mineable area) are exempt from these requirements.

20.2 Outside Surface Mineable Areas

Wells not exceeding 200 m in total depth and within 10 km of the Surface Mineable Areas may conform to the same blowout prevention and drilling practices as inside the Surface Mineable Areas.

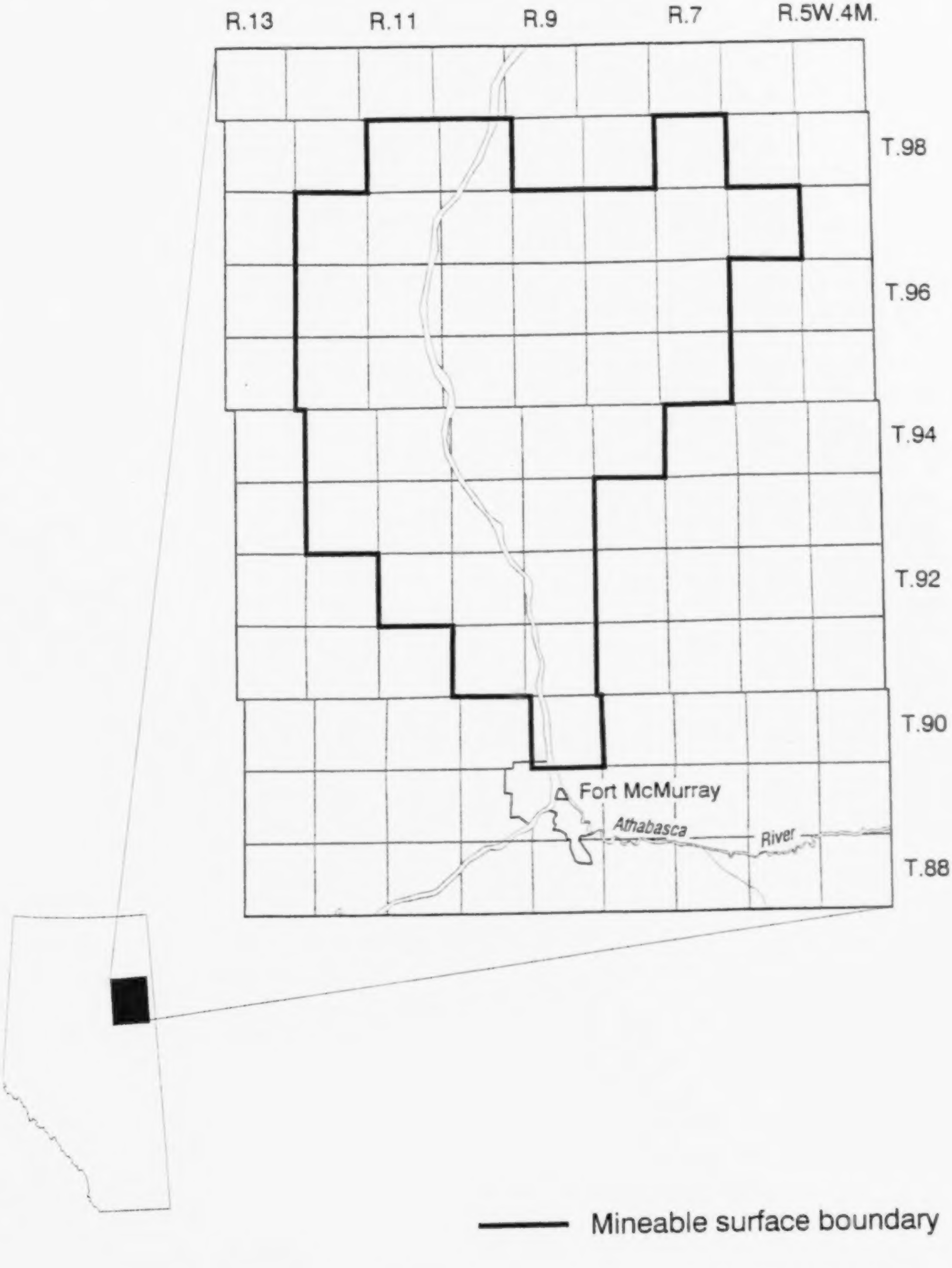

R.13
R.11
R.9
R.7
R.5W.4M.
T.98
T.96
T.94
T.92
T.90
T.88
Fort McMurray
Athabasca
River
Mineable surface boundary

Figure 7. Surface mineable areas

21 Drilling with a Service Rig and Servicing with a Drilling Rig

21.1 Drilling with a Service Rig

21.1.1 Drilling More Than 50 m or More Than One Hydrocarbon-Bearing Formation

When the licensee is conducting drilling operations with a service rig, the operation is classified as a drilling operation if

- **more** than 50 m measured depth of new hole will be drilled, or
- **more** than one potential hydrocarbon-bearing formation will be penetrated.

All requirements set out in *Guide 36: Drilling Rig Inspection Manual* must be complied with.

Any modification to these requirements by the licensee requires formal approval from the EUB Well Operations Group in Calgary.

21.1.2 Drilling Not More Than 50 m or Not More Than One Hydrocarbon-Bearing Formation

When the licensee is conducting drilling operations with a service rig, the operation is classified as a servicing operation if

- **not more** than 50 m measured depth of new hole will be drilled, or
- **not more** than one potential hydrocarbon-bearing formation will be penetrated.

All requirements for the well class set out *Guide 37: Service Rig Inspection Manual* (with special attention to Section 8) must be complied with.

Any modifications to these requirements by the licensee requires formal approval from the EUB Well Operations Group in Calgary.

21.2 Servicing with a Drilling Rig

When a licensee is servicing a well (running tubing, perforating, acidizing, fracing, etc.) with a drilling rig, the operation is classified as a servicing operation and all requirements set out in *Guide 37* must be complied with.

Any modification to this requirement by the licensee requires formal approval from the EUB Well Operations Group in Calgary.

Deficiencies found during any of the above operations will be categorized according to the criteria set out in the appropriate EUB rig inspection manual, *Guide 36* or *Guide 37*.

22 Coiled Tubing

Minimum drilling blowout prevention systems for coiled tubing operations are provided in Figures 8 through 13.

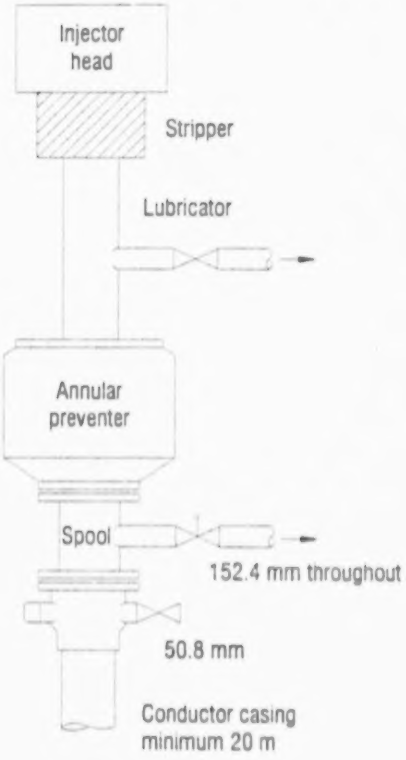
When a coiled tubing unit (CTU) is conducting an overbalanced drilling operation, all requirements (e.g., equipment, procedures, spacing, training) set out in this guide must be met. (There will be some minor differences between conventional drilling rigs and CTUs with regard to the crew shut-in procedures [while drilling, tripping, or out of the hole; see Appendix 11] and BOP function testing [see Section 5.4]).

When a CTU is conducting an underbalanced drilling operation, all requirements in this guide and the additional requirements set out in *ID 94-3: Underbalanced Drilling* must be complied with.

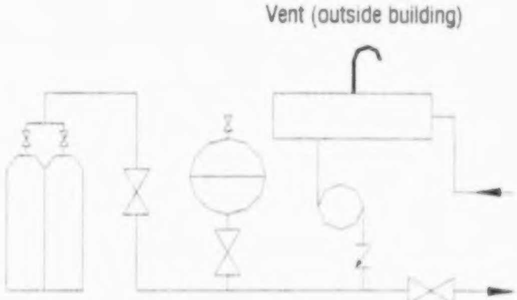
Figure 8. Coiled tubing, Class I—minimum pressure rating 3500 kPa

Drilling blowout prevention systems for

- wells without surface casing terminating in the Upper Cretaceous (i.e., above the Viking Zone) and/or not exceeding a true vertical depth of 750 m
- heavy oil/oil sands wells where a surface casing reduction has been approved
- wells where surface casing is required to be set at a depth greater than 450 m
- wells where hydrocarbon-bearing formations may be encountered above the required surface casing setting depth


Injector head
Stripper
Lubricator
Annular preventer
Spool
152.4 mm throughout
50.8 mm
Conductor casing minimum 20 m

BLOWOUT PREVENTION STACK

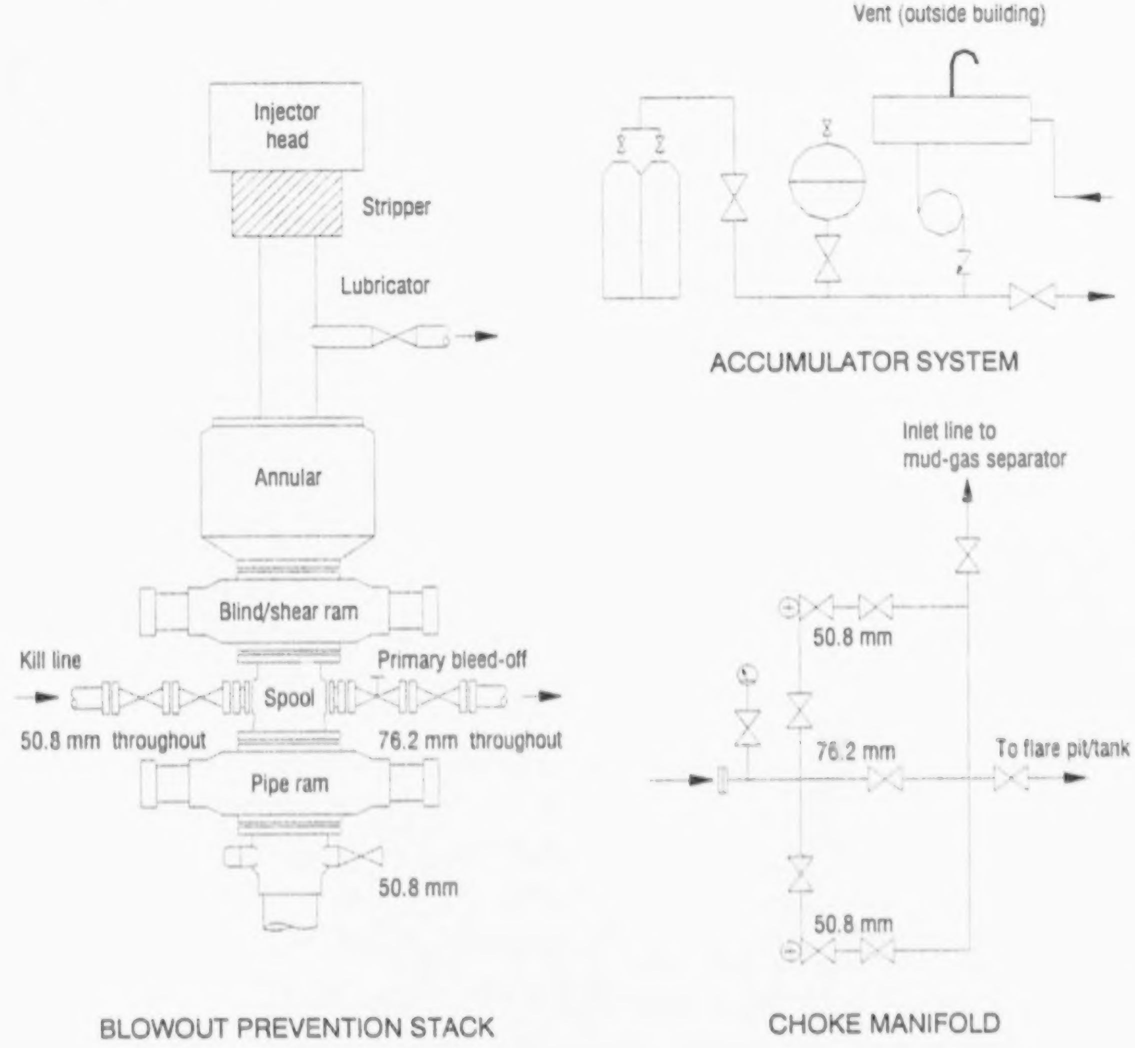

Vent (outside building)

ACCUMULATOR SYSTEM

Note:
1. The diverter line must be a minimum nominal diameter of 152 mm throughout.
2. Connections between the top of annular preventer and injector head do not have to be flanged.
3. See Appendix 2 for equipment symbols.

Figure 9. Coiled tubing, Class II—minimum pressure rating 7000 kPa

Drilling blowout prevention systems for wells not exceeding a true vertical depth of 750 m

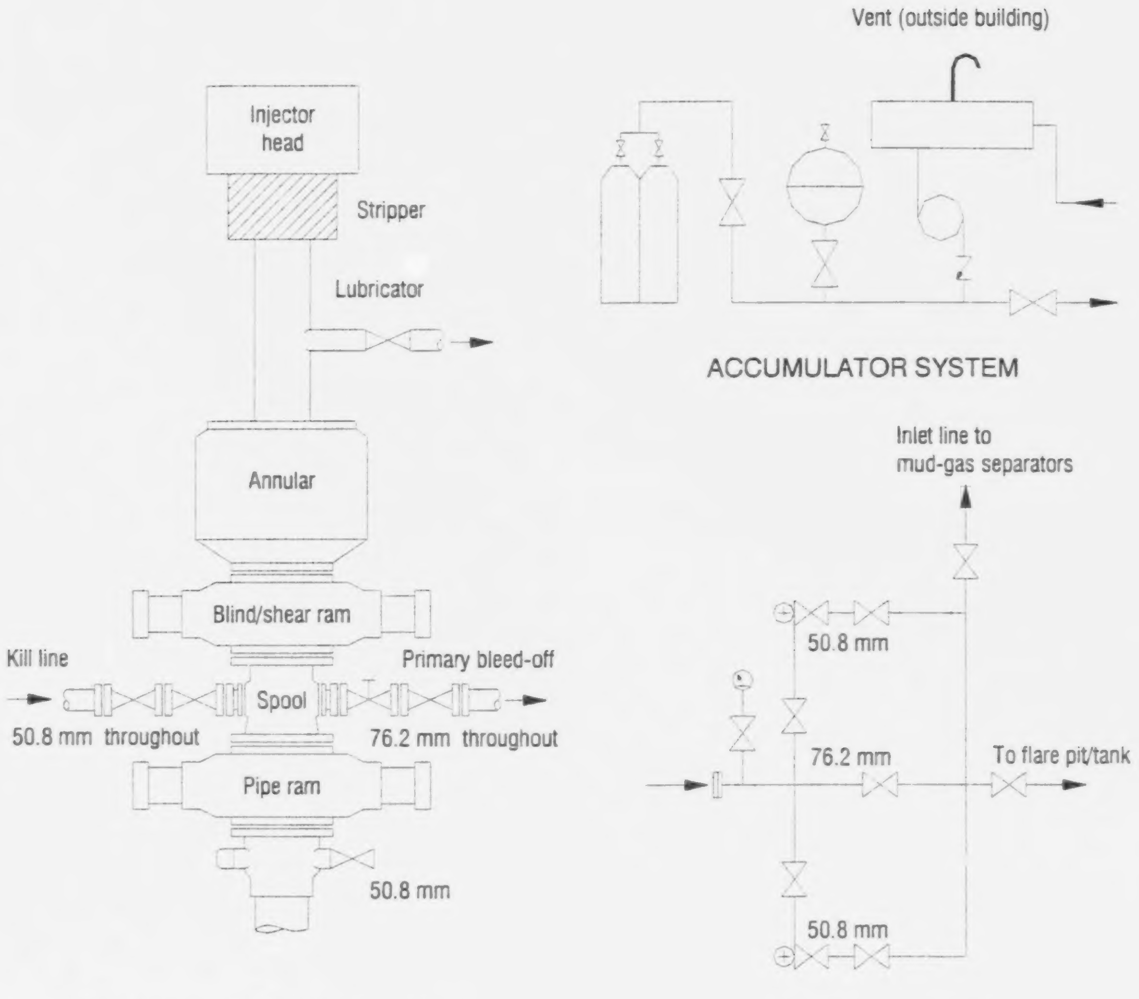

Vent (outside building)
Injector head
Stripper
Lubricator
ACCUMULATOR SYSTEM
Inlet line to mud-gas separator
Annular
Blind/shear ram
Kill line
Primary bleed-off
Spool
50.8 mm throughout
76.2 mm throughout
Pipe ram
50.8 mm
50.8 mm
76.2 mm
To flare pit/tank
50.8 mm
BLOWOUT PREVENTION STACK
CHOKE MANIFOLD

Note:

1. Bleed-off line, centreline through choke manifold, and flare line must be a minimum nominal diameter of 76.2 mm throughout.
2. Lines through chokes must be a minimum nominal diameter of 50.8 mm throughout.
3. Kill line must be a minimum nominal diameter of 50.8 mm throughout.
4. Flanged pipe connections must be used from the drilling spool down to and including the connection to the choke manifold. The remainder of the choke manifold may contain threaded fittings.
5. Connections between the top of annular preventer and injector head do not have to be flanged.
6. Hydraulic and manual valve positions in bleed-off line are interchangeable.
7. See Appendix 2 for equipment symbols.

Figure 10. Coiled tubing, Class III—minimum pressure rating 14 000 kPa

Drilling blowout prevention systems for wells not exceeding a true vertical depth of 1800 m


Vent (outside building)
Injector head
Stripper
Lubricator
Annular
Blind/shear ram
Kill line
Primary bleed-off
Spool
50.8 mm throughout
76.2 mm throughout
Pipe ram
50.8 mm
Inlet line to mud-gas separators
50.8 mm
76.2 mm
To flare pit/tank
50.8 mm

ACCUMULATOR SYSTEM

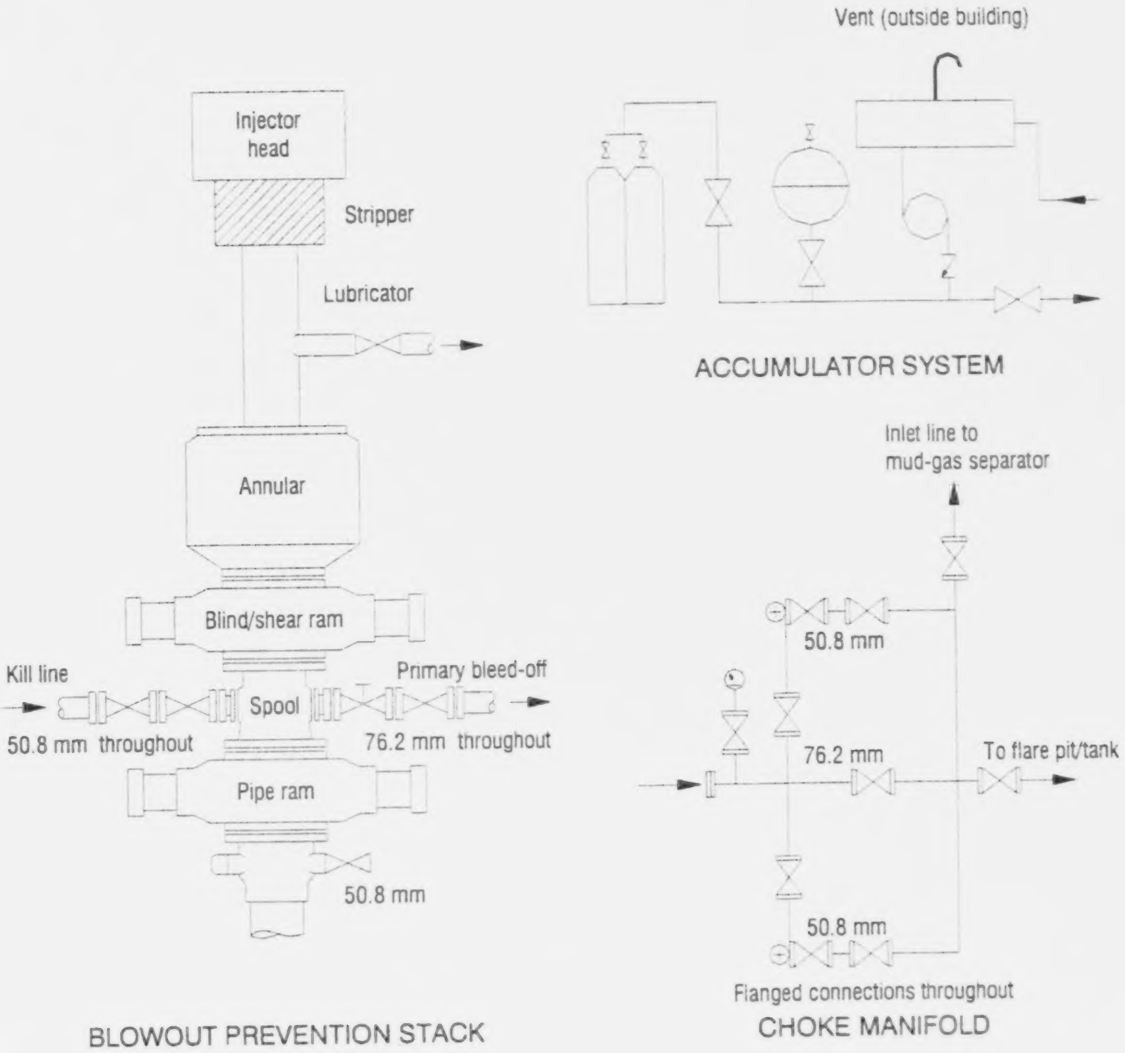
BLOWOUT PREVENTION STACK

CHOKE MANIFOLD

Note:
1. Bleed-off line, centreline through choke manifold and flare line must be a minimum nominal diameter of 76.2 mm throughout.
2. Lines through chokes must be a minimum nominal diameter of 50.8 mm throughout.
3. Kill line must be a minimum nominal diameter of 50.8 mm throughout.
4. Flanged pipe connections must be used from the drilling spool down to and including the connection to the choke manifold. The remainder of the choke manifold may contain threaded fittings.
5. Connections between the top of annular preventer and injector head do not have to be flanged.
6. Hydraulic and manual valve positions in bleed-off line are interchangeable.
7. See Appendix 2 for equipment symbols.

Figure 11. Coiled tubing, Class IV—minimum pressure rating 21 000 kPa

Drilling blowout prevention systems for wells not exceeding a true vertical depth of 3600 m



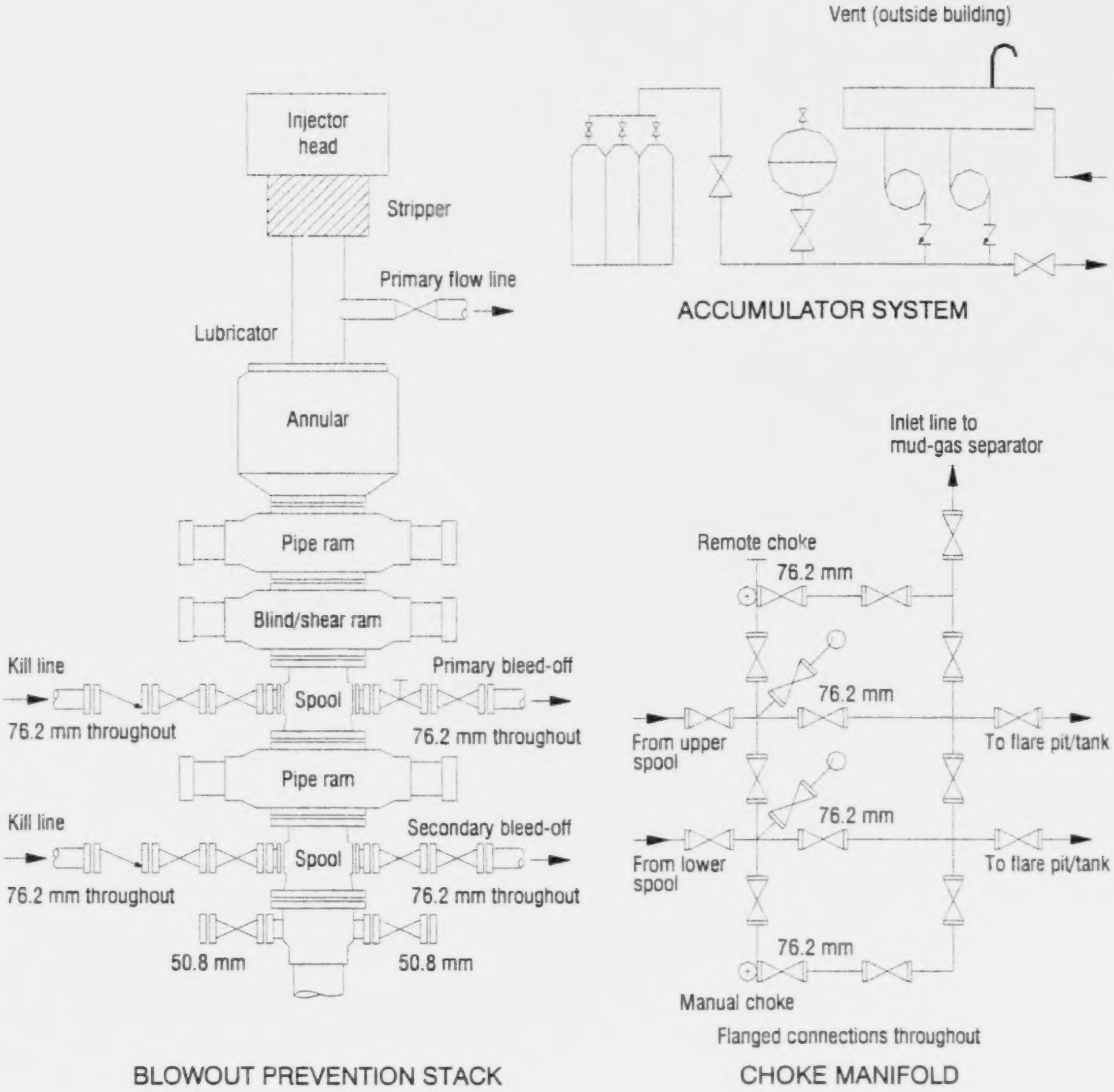
Vent (outside building)
Injector head
Stripper
Lubricator
ACCUMULATOR SYSTEM
Annular
Inlet line to mud-gas separator
Blind/shear ram
Kill line
Primary bleed-off
Spool
50.8 mm throughout
76.2 mm throughout
50.8 mm
76.2 mm
To flare pit/tank
Pipe ram
50.8 mm
50.8 mm
Flanged connections throughout
BLOWOUT PREVENTION STACK
CHOKE MANIFOLD

Note:

1. Bleed-off line, centreline through choke manifold, and flare line must be a minimum nominal diameter of 76.2 mm throughout.
2. Lines through chokes must be a minimum nominal diameter of 50.8 mm throughout.
3. Kill line must be a minimum nominal diameter of 50.8 mm throughout.
4. Flanged pipe connections must be used from the drilling spool to the last valve on the choke manifold, inclusive.
5. Connections between the top of annular preventer and injector head do not have to be flanged.
6. Hydraulic and manual valve positions in bleed-off line are interchangeable.
7. See Appendix 2 for equipment symbols.

Figure 12. Coiled tubing, Class V—minimum pressure rating 34 000 kPa

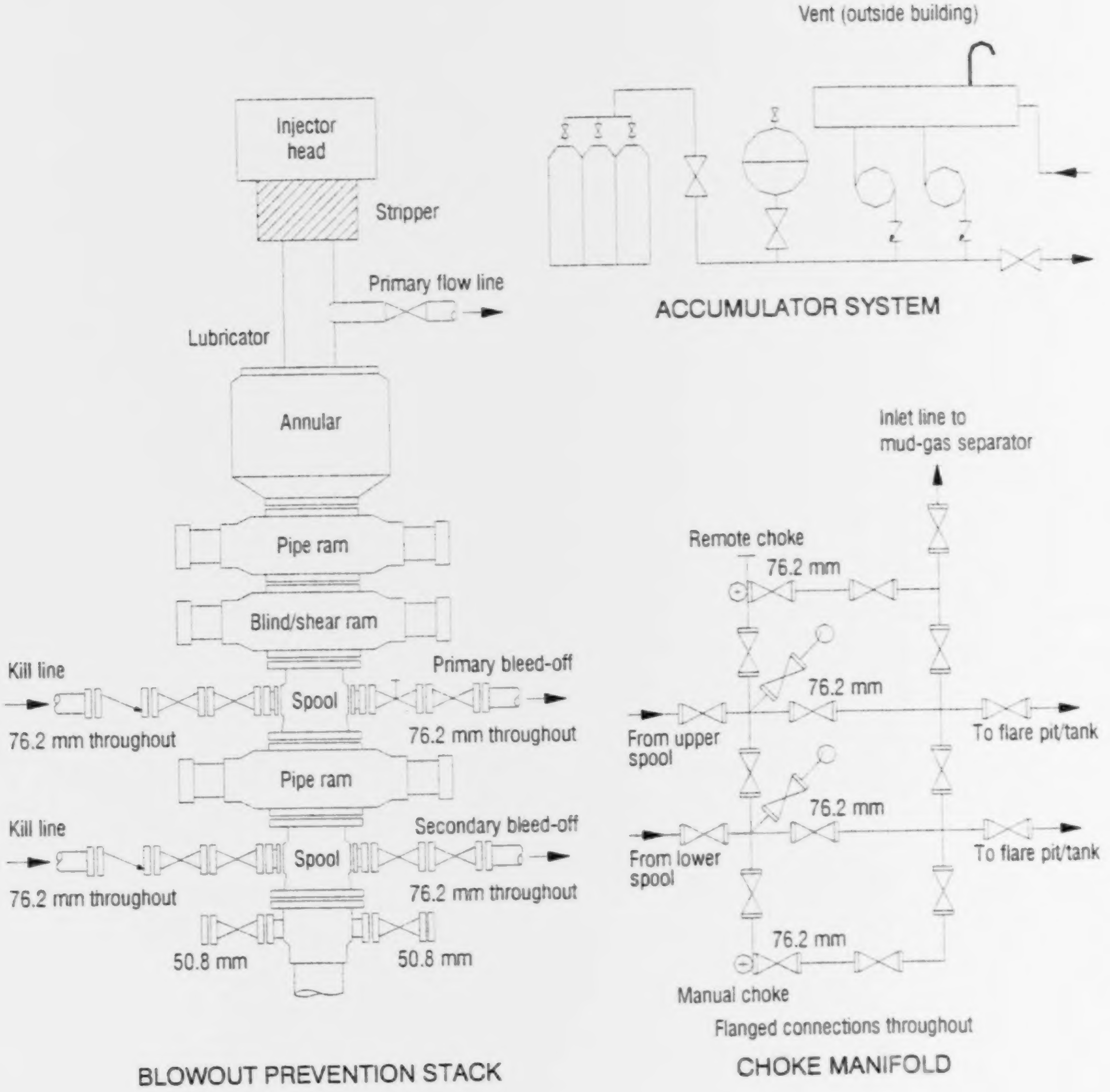
Drilling blowout prevention systems for wells not exceeding a true vertical depth of 6000 m


Vent (outside building)
ACCUMULATOR SYSTEM
Injector head
Stripper
Primary flow line
Lubricator
Annular
Pipe ram
Blind/shear ram
Kill line
Primary bleed-off
Spool
76.2 mm throughout
76.2 mm throughout
Pipe ram
Kill line
Secondary bleed-off
Spool
76.2 mm throughout
76.2 mm throughout
50.8 mm
50.8 mm
BLOWOUT PREVENTION STACK
Inlet line to mud-gas separator
Remote choke
76.2 mm
76.2 mm
From upper spool
To flare pit/tank
76.2 mm
From lower spool
To flare pit/tank
76.2 mm
Manual choke
Flanged connections throughout
CHOKE MANIFOLD

Note:
1. Kill lines, bleed-off lines, choke manifold and flare lines must be minimum nominal diameter of 76.2 mm throughout.
2. Flanged pipe connections must be used from the drilling spool to the last valve on the choke manifold, inclusive.
3. Connections between the top of annular preventer and injector head do not have to be flanged.
4. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
5. See Appendix 2 for equipment symbols.

Figure 13. Coiled tubing, Class VI—minimum pressure rating 69 000 kPa

Drilling blowout prevention systems for wells exceeding a true vertical depth of 6000 m


Vent (outside building)
Injector head
Stripper
Primary flow line
Lubricator
ACCUMULATOR SYSTEM
Annular
Pipe ram
Blind/shear ram
Kill line
Primary bleed-off
Spool
76.2 mm throughout
76.2 mm throughout
Pipe ram
Kill line
Secondary bleed-off
Spool
76.2 mm throughout
76.2 mm throughout
50.8 mm
50.8 mm
BLOWOUT PREVENTION STACK
Inlet line to mud-gas separator
Remote choke
76.2 mm
76.2 mm
From upper spool
To flare pit/tank
76.2 mm
From lower spool
To flare pit/tank
76.2 mm
Manual choke
Flanged connections throughout
CHOKE MANIFOLD

Note:

1. Kill lines, bleed-off lines, choke manifold, and flare lines must be minimum nominal diameter of 76.2 mm throughout.
2. Flanged pipe connections must be used from the drilling spool to the last valve on the choke manifold, inclusive.
3. Connections between the top of annular preventer and injector head do not have to be flanged.
4. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
5. See Appendix 2 for equipment symbols.

23 Well-Site Spacing

23.1 Well-Site Spacing Requirements

Minimum well-site spacing requirements are listed below. For further information refer to the indicated section(s). A spacing diagram is provided in Appendix 6.

23.2 Diverter Lines

The end of diverter line must terminate the minimum required distance from the well in a flare pit or flare tank (see Section 2.1.1.1).

23.3 Flare Lines

The end of the flare line(s) must terminate a minimum of 50 m from the wellbore (see Section 2.1.2.3).

23.4 Flexible Hoses in the Bleed-off and Kill System

Flexible hoses in the diverter, bleed-off, kill, and degasser inlet lines without fire sheathing must be located a minimum of 7 m from the wellbore (see Sections 3.1 and 3.3).

Flexible hose(s) used in the flare line(s) must not be located within 9 m of the flare pit or flare tank (see Section 3.2).

23.5 Flare Tanks and Pits

Flare tanks and pits must be a minimum of 50 m from the wellbore (for exceptions to this requirement, see *ID 91-3: Heavy Oil/Oil Sands Operations, Guide 8: Surface Casing Depth Minimum Requirements*, and Sections 2.1.3 and 2.1.4 of this guide).

23.6 Accumulators, N_2 Backup, and Remote BOP Controls

Accumulators, N_2 backup, and the remote controls must be a minimum of 15 m from the wellbore (see Sections 5.1, 5.2, and 5.3.2).

23.7 Hydraulic BOP Hoses

All nonsteel accumulator hydraulic lines (without fire sheathing) must be a minimum of 7 m from the wellbore (see Section 5.1).

23.8 Engines

All diesel and gasoline engines not equipped with shutoff devices must be a minimum of 25 m from the wellbore, oil storage tank(s), or other source(s) of ignitable vapours (see Section 7).

23.9 Engine Exhaust

Internal combustion engine exhausts must be a minimum of 6 m from the vertical centreline (projected upward) of the wellbore (see Section 7.2).

23.10 Electrical and/or Flame-Type Equipment

Electrical equipment (that is a potential source of ignition) and/or flame-type equipment must be a minimum of 25 m from the wellbore, oil storage tank(s), or other source(s) of ignitable vapours (see Section 11).

23.11 Incinerators and/or Burn Pits

Incinerators and burn pits must be a minimum of 50 m from the wellbore, oil storage tank(s), or other source(s) of ignitable vapours (see Section 11.4).

23.12 Smoking

Smoking is not permitted within 25 m of the wellbore, oil storage tank(s), or other source(s) of ignitable vapours (see Section 11.5).

23.13 Storage Tanks

Oil storage tank(s) must be a minimum of 50 m from the wellbore (see Section 18.3).

Make-up reserve for hydrocarbon based drilling fluid must be stored a minimum of 25 m from the wellbore (see Section 18.1).

Make-up reserve for hydrocarbon-based drilling fluid must be stored a minimum of 50 m from a flare pit/tank, incinerator, or burn pit (see Section 18.1).

Appendix 1 Operational Deficiencies

A drilling rig inspection is normally conducted after the licensee has set surface casing and drilled out the shoe or after the commencement of drilling operations with a diverter system.

Deficiencies will not be recorded prior to drilling out the surface casing shoe or prior to the commencement of drilling operations with a diverter system.

The level of each deficiency is based on the criteria set out in *IL 99-4: EUB Field Surveillance Enforcement Process and Ladder*.

Definitions of Unsatisfactory Inspections

- **Minor unsatisfactory event/inspection (U)** — a contravention of regulation(s) or requirement(s) that does not result in a direct threat to the public or the environment and does not adversely affect oil and gas operations.
- **Major unsatisfactory event/inspection (M)** — a contravention of regulation(s) or requirement(s) that an operator has failed to address or that has the potential to cause an adverse impact on the public or the environment.
- **Serious unsatisfactory event/inspection (S)** — a total disregard for regulation(s) or requirement(s) that is having or may have a significant impact on the public or the environment.

The EUB may escalate noncompliance issue(s) to any level should conditions warrant.

Compliance and Noncompliance Results

Inspection results are rated "X" - satisfactory, "U" - minor unsatisfactory, "M" - major unsatisfactory, or "S" - serious unsatisfactory.

Items below are numbered in accordance with the Drilling and Servicing Inspection Report and the section Inspection Items Detailed and are therefore not always sequential.

1. Blowout Prevention System

1.1 BOP Preventer (BOP) Equipment

S 1. No BOP(s) installed on well.

M 2. BOP pressure rating and/or stack arrangement (including spools) does not meet minimum requirements for the well classification.

U 3. BOPs not adequately supported and/or secured (to substructure).

1.1.1 Metallic Material for Sour Service

M 1. BOP equipment (including spools) does not meet *NACE MR0175* requirements (critical sour wells).

1.1.2 Pipe Rams

M 1. Improper pipe ram size for drill pipe or tubulars that are in use.

M 2. Pipe rams changed out and pressure test on rams not conducted.

1.1.3 Casing Rams

M 1. Casing rams installed and pressure test on rams not conducted.

1.1.4 Ram Locking Devices (Hand Wheels)

U 1. Ram locking devices not readily available, incorrectly sized, and/or cannot be installed.

1.1.5 Double Drilling/Studding

M 1. Double-drilled/studded BOP equipment (including spools) does not meet requirements.

1.1.6 Flange- and Clamp-Type Connections

M 1. BOP system flange/clamp-type connections improperly designed.

U 2. Bolts loose and/or missing from BOP system (spools, flanges, etc.).

M 3. Connection(s) loosened or taken apart and pressure test on connection(s) not conducted.

1.2 Casing Bowls

M 1. Sliplock type, threaded, or weld-on casing bowl not used on class I wells.

M 2. Threaded or weld-on casing bowl not used on well classes II to VI and critical sour wells.

1.2.1 Sliplock

M 1. Sliplock type casing bowl not installed and/or maintained in accordance with manufacturer's specifications.

1.2.2 Threaded

M 1. Threaded casing bowl not properly installed (with regard to make-up procedures, torque, and the use of thread compounds).

1.2.3 Welded

M 1. Casing bowl not welded in accordance with acceptable procedures.

1.2.4 Casing Bowl Flange, Outlet(s), and Valve(s)

M 1. Casing bowl flange not integral part of casing bowl.

M 2. Casing bowl does not have a side outlet and valve (well classes I, II, III, and IV).

M 3. Casing bowl does not have flanged or studded outlet(s) and valve(s) (classes V and VI and critical sour wells).

1.2.5 Pressure Rating

M 1. Casing bowl and/or casing bowl valve does not meet minimum pressure rating requirements.

U 2. Casing bowl specifications not available at the rig.

1.3 Drill-Through Components

U 1. Drill-through components above BOPs not removable with pipe/tools in the hole.

1.4 Stabbing Valve and Inside BOP

M 1. Stabbing valve and/or closing handle not on location.

M 2. Inside BOP not on location.

M 3. Stabbing valve not certified as being capable of opening with 7000 kPa pressure below the valve (well classes V and VI and critical sour wells).

U 4. Stabbing valve and/or hanger cap not full opening.

U 5. Stabbing valve in closed position.

M 6. Stabbing valve and/or inside BOP not operable.

M 7. Stabbing valve and/or valve operating wrench not readily accessible.

M 8. Inside BOP not readily accessible.

M 9. Drill string crossover sub(s) not available or readily accessible.

U 10. Stabbing valve carrying handles and/or hanger cap not provided (when required).

M 11. Stabbing valve and/or inside BOP cannot be stripped into the well (carrying handles and/or hanger cap not removable).

M 12. Stabbing valve and/or inside BOP does not meet *NACE MR0175* standards (critical sour well).

1.5 Lower Kelly Cock Valve

M 1. Lower kelly cock not installed and/or not operable (well classes V and VI and critical sour wells).

M 2. Lower kelly cock not equipped with valve operating wrench.

M 3. Lower kelly cock not certified as being capable of opening with 7000 kPa pressure below the valve.

M 4. Lower kelly cock does not meet *NACE MR0175* standards (critical sour well).

1.6 Stripping Operations

M 1. Stripping of a connection/tool joint through an annular preventer that is part of the required BOP equipment.

M 2. Stripping drill pipe through a pipe ram that is part of the required BOP equipment.

1.7 Shop Servicing and Testing of BOPs, BOP Spools, and Flexible Bleed-off and Kill-line Hoses

M 1. BOP certification (shop servicing and testing) does not meet minimum requirements.

U 2. BOP certification (shop servicing and testing) has expired.

U 3. Shop servicing, testing, and storage documents not available at the rig.

2. Bleed-off and Kill Systems

2.1.1 Class I Wells

2.1.1.1 Diverter Line

M 1. Diverter line does not meet minimum size (throughout) and/or working pressure requirements.

M 2. HCR not installed.

M 3. Fluid turns and/or pipe extensions between drilling spool and HCR.

M 4. Right-angle fluid turns not used for directional changes in diverter line (downstream of HCR).

M 5. Diverter line connections not flanged, hammer union, or threaded.

U 6. Diverter line improperly connected (e.g., loose unions, bolts, etc.).

M 7. Diverter line not connected.

U 8. Diverter line does not terminate in a flare pit or flare tank.

U 9. End of diverter line does not terminate the minimum required distance from the wellbore.

U 10. Diverter line not adequately secured.

U 11. Fluid turn installed at end of diverter line (flare pit in use).

M 12. Diverter line not self-draining and no means incorporated to ensure that fluid can be drained (winter operations only).

U 13. Visual inspection of diverter line not conducted and/or recorded.

2.1.2 Well Classes II to VI and Critical Sour Wells

2.1.2.1 Bleed-off Line(s)

M 1. Bleed-off line(s) does not meet minimum design requirements (e.g., size, number of lines, valves, and working pressure).

M 2. HCR not installed (primary bleed-off line).

M 3. Fluid turns and/or pipe extensions between drilling spool, HCR, and manual valve(s).

M 4. Right-angle fluid turns not used for directional changes in bleed-off line (downstream of HCR, and manual valve(s)).

M 5. Bleed-off line flange/clamp-type connections improperly designed.

U 6. Bolts loose and/or missing from bleed-off line.

M 7. Bleed-off line(s) not connected to the drilling spool and/or choke manifold.

U 8. Bleed-off line(s) not adequately secured/supported.

M 9. Manual valve(s) (next to HCR) not operable.

U 10. HCR in open position during normal drilling operation.

U 11. Manual valve(s) (next to HCR) in the closed position.

U 12. More than one valve on secondary bleed-off line in the closed position.

U 13. Valve handles not installed on bleed-off line(s) valve(s).

M 14. Bleed-off line(s) does not meet *NACE MR0175* standards (critical sour wells).

2.1.2.2 Choke Manifold

M 1. The choke manifold does not meet the minimum pressure rating and/or conform to the configuration (valves, chokes, piping, etc.) for the class of well being drilled.

U 2. The remote choke is not a nonrubber sleeved choke (critical sour well).

U 3. No adjustable choke specifications to identify the fully open and the fully closed position on the choke body and/or on the actuator.

U 4. Valve handles missing on choke manifold valve(s).

M 5. Choke manifold valve(s) not operable.

M 6. Choke manifold casing pressure gauge not installed or readily accessible for installation at choke manifold and/or remote choke control.

U 7. Choke manifold and/or remote choke control casing pressure gauge out of calibration.

M 8. Choke manifold and/or remote choke control casing pressure gauges not available for each wing of choke manifold.

U 9. Choke manifold and/or remote choke control casing pressure gauge does not have readable increments of 250 kPa or less (only surface casing is set).

U 10. MACP exceeds choke manifold and/or remote choke control casing pressure gauge range (only surface casing is set).

U 11. Choke manifold and/or remote choke control casing pressure gauge does not have readable increments of 500 kPa or less (intermediate casing is set).

U 12. Range of choke manifold and/or remote choke control casing pressure gauge less than the pressure rating of the required BOP system (intermediate casing is set).

M 13. Isolation valve not provided for choke manifold and/or remote choke control casing pressure gauge(s).

M 14. Choke manifold does not meet *NACE MR0175* standards (critical sour well).

2.1.2.2(a) Remote Drill Pipe Pressure Gauge Assembly at Choke Control

M 1. Remote drill pipe pressure gauge(s) not provided or readily accessible for installation at choke manifold and remote choke location (if in use and/or required).

U 2. Remote drill pipe pressure gauge inadequate (e.g., out of calibration).

M 3. Isolation valve(s) not provided for remote drill pipe pressure gauge at choke manifold and remote choke location (if in use and/or required).

2.1.2.3 Flare Line(s)

M 1. Flare line does not have a minimum nominal pressure equal to that of the required BOP system.

M 2. Flare line does not have a minimum inside diameter of 76.2 mm throughout.

M 3. Right-angle fluid turns not used for directional changes in flare line.

M 4. Flare line connections not flanged, hammer union, or threaded.

U 5. Flare line improperly connected (e.g., loose unions, bolts).

M 6. Flare line not connected to the choke manifold.

U 7. Flare line does not terminate in a flare pit or flare tank.

U 8. End of flare line does not terminate 50 m from the wellbore.

U 9. Flare line not adequately secured.

U 10. Fluid turn installed at end of flare line (flare pit in use).

M 11. Flare line not self-draining and no means incorporated to ensure that fluid can be drained (winter operations only).

U 12. Visual inspection of flare line not conducted and/or recorded.

M 13. Two flare lines (minimum) not installed (well classes V and VI and critical sour wells).

M 14. Flare line(s) does not meet *NACE MR0175* standards (critical sour wells).

2.1.2.4 Mud-Gas Separators—Degasser

2.1.2.4(a) Primary Degasser

M 1. Primary degasser does not meet minimum sizing requirements for well depth.

M 2. Primary degasser improperly designed (open bottom, construction, etc.).

M 3. Primary degasser not connected to a separate vent line(s).

M 4. Primary degasser not ready for service and fully connected.

M 5. Primary degasser located in trip tank.

M 6. Primary degasser does not meet *NACE MR0175* standards (critical sour wells).

2.1.2.4(b) Secondary Degasser (Critical Sour Wells)

M 1. Secondary degasser does not meet minimum sizing requirements for well depth.

M 2. Secondary degasser improperly designed (construction, etc.).

M 3. Secondary degasser not connected to a separate vent line(s).

M 4. Secondary degasser not ready for service and fully connected.

M 5. Secondary degasser located in trip tank (compartment cannot be equalized with other rig tank compartments).

M 6. Secondary degasser does not meet *NACE MR0175* standards.

2.1.2.4(c) Degasser Inlet

M 1. Degasser inlet line(s) does not have a minimum working pressure equal to that of the required BOP system.

M 2. Degasser inlet line(s) does not meet minimum sizing requirements for well depth.

M 3. Degasser inlet line connections not flanged, hammer union, or threaded.

M 4. Right-angle fluid turns not used for directional changes in degasser inlet line.

U 5. Degasser inlet line improperly connected (e.g., loose unions, bolts).

M 6. Degasser inlet line not connected to the choke manifold and degasser.

U 7. Valve(s) or other restrictions in the degasser inlet line (downstream of the last valve on the choke manifold).

U 8. Degasser inlet line not adequately secured.

U 9. Visual inspection of degasser inlet line not conducted and/or recorded.

M 10. Separate degasser inlet lines not installed from each manifold wing to each degasser (critical sour well with two degassers deployed).

M 11. Degasser inlet line(s) does not meet *NACE MR0175* standards (critical sour wells).

2.1.2.4(d) Degasser Vent Line

U 1. Vent line not made of suitable material composition (e.g., does not maintain its shape).

U 2. Vent line connections do not have adequate seals.

M 3. Vent line size inadequate for mud tank fluid level.

U 4. Vent line not self-draining and no means incorporated to ensure that fluid can be drained.

U 5. Vent line not void of fluids during drilling operations.

U 6. Vent line not adequately secured to mud tank.

U 7. Vent line wall thickness and internal diameter not consistent throughout.

U 8. End of vent line does not terminate 50 m (minimum) from the wellbore in a flare pit or flare tank.

M 9. Separate vent lines not installed from each degasser to the flare pit/tank (critical sour well with two degassers deployed).

U 10. Vent lines do not meet *NACE MR0175* standards (critical sour wells).

2.1.3 Flare Pits

U 1. Flare pit not constructed to contain a minimum of 8 m^3 of fluid.

U 2. Flare pit not constructed with side and back walls 2 m above ground level.

U 3. Flare pit not constructed to resist erosion of a high-pressure flow of gas or liquid.

U 4. Flare pit not located a minimum distance of 50 m from the wellbore.

2.1.4 Flare Tanks

M 1. Flare tank not constructed of steel.

U 2. Flare tank does not have an impingement plate.

U 3. Flare tank does not have a minimum of 8 m^3 capacity.

M 4. Flare tank not open to atmosphere.

U 5. Flare tank not the minimum required distance from the wellbore.

U 6. Flare tank does not have a minimum 76.2 mm liquid loading steel line that is connected at all times extending a minimum of 9 m from the tank.

U 7. Liquid in flare tank cannot be isolated from the vent line.

2.2. Kill System

2.2.2 Well Classes II-VI

M 1. Kill line does not meet the minimum pressure rating of the required BOP system (from the drilling spool connection to the isolation valve on the mud line/standpipe connection).

M 2. Kill line does not have the required minimum inside diameter (throughout).

U 3. Kill lines do not have two flanged valves installed on the drilling spool(s).

U 4 Fluid turns and/or pipe extensions between the drilling spool and the first manual valve.

U 5. Kill line cannot be isolated from the mud line/standpipe.

U 6. Threaded fittings, hammer unions, flange, or clamp-type connections used in the kill system not properly installed and/or made up (this includes all studs, bolts, and nuts, etc.).

U 7. Improper connections used in kill line (from the last valve on the drilling spool to the mud line/standpipe).

U 8. Kill line disconnected in more than one place.

U 9. Kill line valve next to the drilling spool in the open position.

U 10. Valve(s) in the kill system not operable and/or valve handle(s) not installed.

2.2.2.1 Well Classes V and VI and Critical Sour Wells

M 1. Two separate kill lines not provided.

M 2. Flanged check valve not installed in kill line.

U 3. Kill line(s) does not meet *NACE MR0175* standards (critical sour wells).

3. Flexible Hoses

3.1 Bleed-off, Kill, or Diverter Line(s)

M 1. Flexible hose used in bleed-off, kill, or diverter line(s) does not meet the minimum required size (internal diameter) or working pressure.

M 2. Flexible hose used in bleed-off, kill, or diverter line(s) does not have factory-installed connections.

M 3. Flexible hose used in bleed-off, kill, or diverter line(s) (within 7 m of wellbore) does not have adequate fire sheathing.

U 4. Flexible hose used in bleed-off, kill, or diverter line(s) does not maintain its original shape and/or contains bends that exceed the manufacturer's specified minimum bending radius.

U 5. Flexible hose used in bleed-off, kill, or diverter line(s) is not marked so that the manufacturer can be readily identified.

U 6. Flexible hose used in bleed-off, kill, or diverter line(s) is not supported to prevent stresses on connecting valves and piping,

U 7. Flexible hose used in bleed-off, kill, or diverter line(s) is not secured and/or protected from mechanical damage.

U 8. Flexible hose used in the diverter line(s) within 9 m of the flare pit or flare tank.

M 9. Metallic components of flexible hose(s) used in the bleed-off or kill line(s) do not meet *NACE MR0175* standards (critical sour wells).

M 10. Elastomeric components of flexible hose(s) used in the bleed-off or kill line(s) do not meet *NACE TM 0187-87* standards (critical sour wells).

U 11. Three-year shop servicing and testing of flexible hose used in bleed-off, kill, or diverter line(s) does not meet minimum requirements or certification has expired.

3.2 Flare and Emergency Flare Line(s)

M 1. Flexible hose used in the flare or emergency flare line(s) does not have a working pressure equal to or greater than that of the required BOP system.

M 2. Flexible hose used in flare or emergency flare line(s) does not have a minimum internal diameter of 76.2 mm throughout.

M 3. Flexible hose used in flare or emergency flare line(s) does not have factory-installed connections.

M 4. Flexible hose used in flare or emergency flare line(s) (within 7 m of wellbore) does not have adequate fire sheathing.

U 5. Flexible hose used in flare or emergency flare line(s) does not maintain its original shape and/or contains bends that exceed the manufacturer's specified minimum bending radius.

U 6. Flexible hose used in flare or emergency flare line(s) is not supported and/or secured and/or protected from mechanical damage.

U 7. Flexible hose used in the flare or emergency flare line(s) within 9 m of the flare pit or flare tank.

U 8. Metallic components of flexible hose(s) used in the flare line(s) do not meet *NACE MR0175* standards (critical sour wells).

U 9. Elastomeric components of flexible hose(s) used in the flare line(s) do not meet *NACE TM 0187-87* standards (critical sour wells).

3.3 Degasser Inlet Line(s)

M 1. Flexible hose used in the degasser inlet line(s) does not have a working pressure equal to that of the required BOP system.

M 2. Flexible hose used in degasser inlet line(s) does not meet the minimum required size (internal diameter).

M 3. Flexible hose used in degasser inlet line(s) does not have factory-installed connections.

M 4. Flexible hose used in degasser inlet line(s) (within 7 m of wellbore) does not have adequate fire sheathing.

U 5. Flexible hose used in degasser inlet line(s) does not maintain its original shape and/or contains bends that exceed the manufacturer's specified minimum bending radius.

U 6. Flexible hose used in degasser inlet line(s) is not supported and/or secured and/or protected from mechanical damage.

M 7. Metallic components of flexible hose(s) used in the degasser inlet line(s) do not meet *NACE MR0175* standards (critical sour wells).

M 8. Elastomeric components of flexible hose(s) used in the degasser inlet line(s) do not meet *NACE TM 0187-87* standards (critical sour wells).

3.4 Degasser Vent Line

M 1. Flexible hose used in degasser vent line(s) does not meet the minimum required size (internal diameter).

U 2. Flexible hose used in degasser vent line(s) does not maintain its original shape throughout its entire length.

U 3. Flexible hose used in the degasser vent line(s) within 9 m of the flare pit or flare tank.

U 4. Metallic components of flexible hose(s) used in the degasser vent line(s) do not meet *NACE MR0175* standards (critical sour wells).

U 5. Elastomeric components of flexible hose(s) used in the degasser vent line(s) do not meet *NACE TM 0187-87* standards (critical sour wells).

4. Winterizing

4.1 Winterizing BOP, Accumulator, Bleed-off, and Kill Systems

M 1. Insufficient heat provided to the BOP stack and/or all associated valves and/or choke manifold and/or accumulator system to maintain their effectiveness.

M 2. Bleed-off and/or kill and/or flare and/or degasser inlet line(s) are not empty or filled with a nonfreezing fluid or heated during cold weather drilling operations.

5. BOP Control Systems

5.1 Accumulator System

M 1. Accumulator pressure dropped below 8400 kPa after function test (of all required BOP components) with the recharge pump off.

U 2. Accumulator specifications not available at the rig.

M 3. Accumulator hydraulic lines not equal to or greater than the working pressure of the accumulator system.

M 4. Nonsteel accumulator hydraulic lines located within 7 m of the wellbore not equipped with adequate fire-resistant sheathing.

M 5. Fire-resistant sheathing damaged on nonsteel accumulator hydraulic lines located within 7 m of the wellbore.

M 6. Accumulator system not recharged by an automatic pressure-controlled pump.

M 7. Accumulator system not equipped with two separate automatic pressure-controlled recharge pumps for well classes V and VI and critical sour wells.

U 8. Accumulator recharge pump failed to recharge the accumulator within 5 minutes.

M 9. Check valve not installed to allow for replacement of accumulator recharge pump.

U 10. BOP component(s) failed to close within the required time.

M 11. Accumulator not equipped with a gauge showing accumulator system pressure.

U 12. Fittings and/or gauge not available to obtain accumulator bottle(s) precharge pressure.

U 13. Accumulator not readily accessible.

U 14. Accumulator not housed.

U 15. Accumulator not adequately heated to maintain its effectiveness.

U 16. Accumulator not located at least 15 m from the wellbore.

U 17. Accumulator vent not installed so that venting takes place outside the building (side or top of building).

M 18. Accumulator not connected to a backup nitrogen system.

5.2 Backup Nitrogen (N_2) System

U 1. Backup N_2 system improperly connected to accumulator system.

U 2. Gauge not installed (or readily available for installation) to determine the backup N_2 system pressure.

U 3. Backup N_2 system not readily accessible.
U 4. Backup N_2 system not housed.

U 5. Backup N_2 system not adequately heated to maintain its effectiveness.

U 6. Backup N_2 system not located at least 15 m from the wellbore.

5.3 BOP Controls

5.3.1 Floor Controls

M 1. BOP floor controls not provided for each BOP component and the HCR in the bleed-off line.

U 2. BOP floor controls not located near the driller's position.

M 3. BOP floor controls not capable of opening and closing each BOP component and the HCR in the bleed-off line.

U 4. BOP floor control not properly installed and/or correctly identified, and/or function operations (i.e., open and close) not identified.

U 5. BOP floor controls not equipped with a gauge indicating the accumulator system pressure.

5.3.2 Remote Controls

M 1. BOP remote controls not provided for each BOP component and the HCR in the bleed-off line.

M 2. BOP remote controls not capable of opening and closing each BOP component and the HCR in the bleed-off line.

U 3. BOP remote control not properly installed and/or correctly identified, and/or function operations (i.e., open and close) not identified.

U 4. BOP remote controls not equipped with a gauge indicating the accumulator system pressure.

U 5. BOP remote controls not located a minimum of 15 m from the well.

U 6. BOP remote controls not readily accessible.

U 7. BOP remote controls not housed.

U 8. BOP remote controls not adequately heated to maintain their effectiveness.

5.3.3 Master Hydraulic Control Manifold Location

U 1. Master hydraulic control manifold not located at the remote position (critical sour wells).

5.4 BOP Function Test

M 1. BOP(s) or HCR on the bleed-off line failed to operate from the floor position.

M 2. BOP(s) or HCR on the bleed-off line failed to operate from the remote position.

5.4.2 Daily and Weekly

U 1. Required daily and/or weekly BOP/HCR function tests not conducted.

5.4.3 Recording

U 1. Required daily and/or weekly BOP/HCR function tests not recorded in the drilling logbook.

5.5 Accumulator Sizing Calculations

M 1. Accumulator has insufficient usable fluid available to operate the required BOP components and retain on the accumulator system a minimum pressure of 8400 kPa (sizing calculations performed).

M 2. Accumulator has insufficient usable fluid available to operate the required BOP components and to shear the drill pipe and retain on the accumulator system a minimum pressure of 8400 kPa, or the minimum pressure required to shear the drill pipe (whichever is greater) (sizing calculations performed) (critical sour wells).

5.6 Backup Nitrogen Sizing Calculations

M 1. Backup N_2 system has insufficient equivalent litres of N_2 available (at a minimum pressure of 8400 kPa) to operate the required BOP components (sizing calculations performed).

M 2. Backup N_2 system has insufficient usable fluid available to operate the required BOP components and to shear the drill pipe and retain on the accumulator system a minimum pressure of 8400 kPa, or the minimum pressure required to shear the drill pipe (whichever is greater) (sizing calculations performed) (critical sour wells).

6. Pressure Testing

6.1.2 Classes II to VI and Critical Sour Wells

M 1. Low-pressure and/or high-pressure test(s) not conducted on all required components and/or casing strings.

U 2. Pressure tests not conducted using low-viscosity fluid.

U 3. Low-pressure test not conducted before the high-pressure test.

U 4. Stabbing valve and/or lower kelly cock not pressure tested from the bottom.

U 5. Stabilized pressure (of at least 90 per cent of the required test pressure over a minimum 10-minute interval) not attained.

U 6. Pressure test(s) not recorded in the drilling logbook.

U 7. Third-party pressure test documentation not available at the rig.

U 8. Casing hanger plug not run to isolate the casing (test pressure exceeded 67 per cent of the bottomhole pressure at the casing setting depth).

U 9. Minimum 10-minute pressure test not conducted on all required components and/or casing string(s).

U 10. Inadequate test pressure used for low-pressure and/or high-pressure test on all required components and/or casing string(s).

7. Engines

7.1.1 Diesel Engine(s)

U 1. Diesel engine(s) operating within 25 m of the well not equipped with an approved diesel engine shutoff device(s) or not equipped with an air intake that is located 25 m from the well.

U 2. Diesel engine(s) shutoff device does not have a remote control readily accessible from the driller's position to shut down the engine(s).

7.1.2 Gasoline Engine(s)

U 1. Gasoline (including propane) engine(s) operating within 25 m of the well not equipped with an approved engine shutoff device(s).

U 2. Gasoline (including propane) engine(s) shutoff device does not have a remote control readily accessible from the driller's position to shut down the engine(s).

7.1.4 Testing and Recording

U 1. Internal combustion engine shutoff device(s) not tested as required.

U 2. Internal combustion engine shutoff device(s) test results not recorded in the drilling logbook.

7.1.5 Conducting Engine Shutoff Test(s)

U 1. Internal combustion engine shutoff device(s) failed to operate.

7.2 Engine Exhaust

U 1. Engine exhaust(s) do not meet minimum requirements.

8. Mud Tanks and Fluid Volume Monitoring Systems

8.1 Mud Tanks

M 1. Mud tanks not provided.

8.2 Mud Tank Fluid Volume Monitoring System

M 1. Fluid volume monitoring system not provided.

8.2.1 Nonautomated (Nonelectronic) Fluid Level Monitors

M 1. Fluid level monitoring system not capable of measuring a change of ±2 m^3 (maximum) in total tank volume.

M 2. Fluid level monitoring system's float not located in the appropriate mud tank compartment.

M 3. Monitoring indicator does not have readable and/or accurate increments.

M 4. Driller does not know the volume of fluid per increment.

M 5. Monitoring indicator is not readable from and/or located near the driller's position.

M 6. Driller does not know the normal fluid level in the mud tanks.

M 7. The float, cable assembly, and/or monitoring indicator not operating properly.

8.2.2 Automated (Electronic) Mud Tank Fluid Volume Monitoring System

M 1. Automated mud tank fluid volume monitoring system that is electronically operated not used (well classes V and VI, critical sour wells, and all wells drilled with oil-based drilling fluids).

M 2. Monitoring system not equipped with mud tank fluid volume sensors in each active mud tank compartment.

M 3. Monitoring system does not provide accurate and/or continuous mud tank fluid volume readings (that are reported on an electronic monitoring station).

M 4. Electronic monitoring station not readable from and/or located near the driller's position.

M 5. Monitoring system not capable of detecting a change of ± 2 m^3 (± 1 m^3 for critical sour wells) in total tank fluid volume.

M 6. Monitoring system not equipped with an alarm set to detect a change of $\pm$ $2m^3$ in total tank fluid volume.

M 7. The electronic monitoring station not equipped with chart recorders (critical sour wells).

M 8. Visual indicator (i.e., flashing light) does not come on automatically whenever the alarm system is shut off (critical sour wells).

M 9. Driller not familiar with monitoring system.

8.2.3 Automated (Electronic) Mud Tank Fluid Volume Monitoring Systems—Surface Casing Reductions

M 1. Monitoring system does not meet minimum requirements for surface casing reduction (*Guide 8: Surface Casing Depth Minimum Requirements*).

8.3 Trip Tank—Design and Fluid Level Monitoring

M 1. Trip tank with a fluid level-monitoring system not provided, not in use, or not operating properly.

M 2. Monitoring indicator does not have readable and/or accurate increments.

M 3. Suction and/or return lines not connected to the trip tank while tripping.

M 4. Monitoring indicator is not readable from and/or located near the driller's position.

M 5. Driller does not know the volume of fluid per increment.

8.3.1 Well Classes I, II, and III

M 1. Nonautomated fluid monitoring system is in use and trip tank surface area is greater than 3.0 m^2.

M 2. Trip tank surface area is greater than 3.0 m^2 and the automated fluid monitoring system in use is not capable of detecting a change of 0.04 m^3.

8.3.2 Well Classes IV, V, and VI

M 1. Nonautomated fluid monitoring system is in use and trip tank surface area is greater than 6.0 m^2.

M 2. Trip tank surface area is greater than 6.0 m^2 and the automated fluid monitoring system in use is not capable of detecting a change of 0.075 m^3.

8.3.3 Critical Sour Wells

M 1. Trip tank surface area is greater than 3.0 m^2 (critical sour wells).

M 2. Usable trip tank volume is less than 3.0 m^3 (critical sour wells).

M 3. Nonautomated fluid monitoring system is in use and the volume increments on the monitoring board are greater than 0.1 m^3 (critical sour well).

M 4. Automated fluid monitoring system is in use and the volume increments on the monitoring display are greater than 0.0375 m^3 and/or the readout on the monitoring display is not to a minimum of 2 decimal places (critical sour wells).

9. Well-Site Supervision and Certification

9.1 Well-Site Supervision

M 1. Licensee did not provide a qualified on-site representative who is responsible for and restricted to this drilling operation.

M 2. Licensee did not provide a qualified rig manger who is responsible for the supervision of the drilling rig.

M 3. Licensee well-site representative and/or rig manager not readily available.

M 4. Two qualified well-site licensee representatives (working shifts no longer than 12 hours) not provided (critical sour well drilling in the critical zone).

9.1.1 Tripping and Well Control Situations

M 1. Licensee representative or rig manager not present on lease during tripping in or out of the well.

M 2. Licensee representative and rig manager not present on lease during well control situation.

9.2 Blowout Prevention Certificates—Petroleum Industry Training Service (PITS)

9.2.1 First-Line Supervisor's Certificate

M 1. Driller does not possess a valid First-Line Supervisor's Blowout Prevention Certificate.

9.2.2 Second-Line Supervisor's Well Control Certificate

M 1. Licensee well-site representative and/or rig manager does not possess a valid Second-Line Supervisor's Well Control Certificate.

10. Well Control, Crew Training, and Tripping

10.1 Well Control

M 1. Insufficient drilling fluid density to control formation pressure.

M 2. Well control data not provided.

10.1.1 Maximum Allowable Casing Pressure (MACP)

M 1. MACP not posted in the manifold shack and/or at the remote choke location.

10.1.2 Reduced Speed Pump Pressure (RSPP)

U 1. The reduced pump speed and/or reduced pump pressure not recorded in the daily drilling report at least once per tour (hydrocarbon-bearing zones have been penetrated).

10.1.3 Blowout Prevention and Well Control Procedures

U 1. Well control procedures not posted in doghouse.

10.1.4 STICK Diagram

M 1. STICK diagram not posted in doghouse.

M 2. STICK diagram does not contain all the required information.

10.2 Crew Training

10.2.1 BOP Drills

M 1. Required BOP drills not conducted.

10.2.2 Crew Alert Method

M 1. Crew alert device not provided and/or not operable.

10.2.4 Crew Assessment and Procedures

M 1. Crew did not respond to alert.

M 2. Crew training inadequate in the operation of the BOP equipment and/or well control procedures (crew unable to properly shut in well).

U 3. Crew training inadequate in the operation of the BOP equipment and/or well control procedures (well properly shut in, but crew not familiar with all BOP equipment and/or well control procedures).

10.2.5 Recording BOP Drills

U 1. Required BOP drills not recorded in the drilling logbook.

10.3 Tripping

M 1. Trip margin not sufficient to exert an adequate overbalance of the expected formation pressures.

U 2. Bottoms-up circulation not conducted and/or weighted pill not pumped prior to tripping pipe from the well.

10.3.1 Flow Checks

M 1. Ten-minute flow checks not conducted at the required intervals.

U 2. Flow checks not recorded in the drilling logbook.

M 3. Wellbore not filled to surface prior to conducting flow checks.

10.3.2 Hole Filling

M 1. Fluid level in the wellbore dropped more than 30 m from surface while tripping.

10.3.3 Trip Records

M 1. Trip records not being accurately completed.

U 2. Trip records not available at the rig.

11. Electrical and Flame-Type Equipment

11.1 Electrical Appliances and Electrical Devices

U 1. Electrical appliance(s) and/or electrical device(s) that are potential sources of ignition being used within 25 m of the wellbore (wellbore not shut in).

U 2. Electrical appliance(s) and/or electrical device(s) that are potential sources of ignition being used within 25 m of a separator, oil storage tank, or other source of ignitable vapour.

11.2 Electrical Motors and Electrical Generators

U 1. Electrical motors and/or electrical generators that are potential sources of ignition being used within 25 m of a wellbore, separator, oil storage tank, or other source of ignitable vapour (where arcing is produced and motors/generators are not purged).

11.3 Flame-Type Equipment

U 1. Flame-type equipment used within 25 m of the wellbore (wellbore not shut in).

U 2. Flame-type equipment used within 25 m of a separator, oil storage tank, or other source of ignitable vapour.

11.4 Incinerators and Burn Pits

U 1. Incinerators and/or burn pits located within 50 m of the wellbore, separator, oil storage tank, or other source of ignitable vapour.

11.5 Smoking

U 1. Smoking within 25 m of the wellbore, rig, derrick, separator, oil storage tank, or other source of ignitable vapour.

12. Casing Inspection

12.1 30-Day Casing Inspection

U 1. Required casing integrity tests not performed and/or inadequate.

13. Drillstem/Well Testing

13.1 Drillstem Testing (DST)

M 1. Reverse-circulating sub not installed in the drill string.

M 2. Remote-controlled master valve not installed on the testing head.

U 3. Separate DST line(s) not installed, and/or the end of the line(s) does not terminate at least 50 m from the well.

U 4. DST line(s) not secured at 10 m intervals.

M 5. DST manifold does not have (as a minimum) the same pressure rating as the required BOP system.

U 6. DST manifold not secured to restrict it from movement.

U 7. Liquids produced during DST not separated.

U 8. Liquids produced during DST directed to an earthen pit.

14. High-Hazard Area and Surface Casing Reductions

14.1.1 Surface Casing

M 1. Surface casing not set to a minimum depth of 180 m.

14.1.2 Drilling Fluid Density

M 1. Drilling fluid density not adequate to exert a minimum of 1400 kPa overbalance (Mannville Group penetrated).

14.1.3 Emergency Flare Line

M 1. Emergency flare line not installed.

M 2. Emergency flare line does not meet minimum design requirements (e.g., size, valves, working pressure).

M 3. Emergency flare line valves not flanged together and/or not connected directly to the drilling spool.

M 4. Fluid turns and/or pipe extensions between drilling spool and the valves.

M 5. Emergency flare line valves not operable.

U 6. Emergency flare line valve handles not installed.

M 7. Flare line connection to the two valves not flanged and/or remaining connections (downstream of working spool connection) not flanged, hammer union, or threaded.

U 8. Emergency flare line improperly connected (e.g., loose unions, bolts).

U 9. Right-angle fluid turns not used for directional changes in emergency flare line.

U 10. Fluid turn installed at end of emergency flare line (flare pit in use).

U 11. Emergency flare line not adequately secured.

M 12. Emergency flare line is not self-draining and no means incorporated to ensure that fluid can be drained (winter operations only).

U 13. End of emergency flare line does not terminate 50 m from the wellbore.

U 14. Emergency flare line does not terminate in a flare pit or flare tank.

U 15. Visual inspection of emergency flare line not conducted and/or recorded in the drilling logbook.

14.2 Surface Casing Reductions

Deficiencies are classified as set out above in Section 14.1.3 (Emergency Flare Line).

15. Sour and Critical Sour Wells

15.2 Emergency Response Plan (ERP)

S 1. No approved specific ERP where required.

M 2. Copy of ERP not on location.

M 3. Licensee did not conduct review of the ERP with on-site personnel (required to implement the plan) within 96 hours prior to conducting operations in the sour zone.

M 4. Licensee on-site representative not familiar with ERP.

M 5. All equipment specified in ERP not installed and/or on location prior to entering the critical or sour zone.

15.2.1 Communicating with Parties within the EPZ

U 1. Licensee not communicating with residents in the EPZ.

15.3 Warning Sign in H_2S Area

U 1. H_2S warning sign not posted as required.

U 2. H_2S warning sign posted but not required (sweet well).

15.4 Critical Sour Well

15.4.1 Drilling Plan

M 1. Copy of drilling plan not on location.

15.4.2 Intermediate Casing

S 1. Intermediate casing not set as required.

U 2. Intermediate casing waiver not on location.

15.4.3 BOP System and Choke Manifold

M 1. BOP stack configuration does not conform to one of the three BOP stack configurations.

M 2. Ram blanking tool not on location (Configuration 2 or 3 in use).

M 3. BOP stack Configuration 3 in use and insufficient surface or intermediate casing set to contain the maximum anticipated reservoir pressure.

M 4. The choke manifold does not meet the minimum pressure rating for the class of well being drilled and/or conform to the required critical sour well choke manifold configuration (valves, chokes, piping, etc.).

U 5. The remote choke is not a nonrubber sleeved choke.

15.4.4 Shear Blind Rams

M 1. Shear blind rams not installed (where required).

U 2. Shear blind rams waiver not on location.

15.4.5 Drill Pipe

M 1. Drill pipe used not premium class or better grade.

15.4.6 Indicators and Recording Devices

M 1. Indicators for pump pressure, pump strokes per minute, hook load, and/or table torque not installed, and/or operational, and/or visible from the driller's position.

M 2. Continuous recording device(s) not provided to record the rate of penetration, pump pressure, pump strokes per minute, hook load, rotary table revolutions per minute (rpm), and rotary torque.

U 3. Continuous recording device(s) records not available.

15.4.7 H_2S Monitoring

M 1. Drilling fluid pH continuous monitoring system not installed (water-based drilling fluid and drilling in the critical zone).

U 2. Drilling fluid pH continuous monitoring system does not have an alarm to indicate a drop in pH (water-based drilling fluid and drilling in the critical zone).

U 3. Drilling fluid pH not maintained above 10.5 (water-based drilling fluid and drilling in the critical zone).

M 4. Ambient H_2S detector not located at the shale shaker (during drilling in the critical zone).

U 5. Ambient H_2S monitoring system does not have audible and visible alarms located near the driller's position (during drilling in the critical zone).

M 6. Portable ambient H_2S concentration detection device not on location (during drilling in the critical zone).

15.4.8 Sulphide Monitoring

M 1. Drilling fluid sulphide content not monitored as required.

U 2. Records of the sulphide content in the mud not maintained while drilling in the critical zone.

15.4.9 Testing and Coring

M 1. Drillstem test conducted on critical sour zone(s).

M 2. No ability to circulate above the core barrel (when required).

15.4.10 Underbalanced Drilling

M 1. Underbalanced drilling not conducted in accordance with requirements.

S 2. Underbalanced drilling conducted where residents reside in the calculated EPZ (within critical zone).

15.4.11 Personnel

U 1. Licensee and/or contractor representative(s) do not have a current PITS H_2S Alive certification.

U 2. Drilling rig crew member(s) does not have a current PITS H_2S Alive certification.

U 3. Five-man drilling rig crew not provided.
U 4. On-site personnel not trained in H_2S safety.

U 5. Safety personnel and adequate safety equipment for all workers not on site.

15.4.12 Ignition Criteria

M 1. Licensee does not have clear and specific plans in place to ignite an uncontrolled flow.

M 2. Dual ignition system not installed as required.

16. Well-Site Records and Reporting

16.1 Notification of Commencement of Drilling (Spud)

U 1. Licensee did not notify the appropriate Field Centre within 12 hours of the commencement of the drilling of a well.

16.2 Drilling and Completion Data Recording

U 1. Daily record of operations not recorded in the drilling logbook.

16.3 Loss of Circulation, Kicks, Blows, and Blowouts

16.3.1 Loss of Circulation—Recording and Reporting

U 1. Loss of circulation not recorded in the drilling logbook.

M 2. Loss of circulation not reported to the EUB (well requires an EUB-approved ERP).

16.3.2 Kick—Recording and Reporting

U 1. Kick not recorded in the drilling logbook.

M 2. Kick not reported to the EUB (well requires an EUB-approved ERP).

16.3.3 Blow—Recording and Reporting

U 1. Blow not recorded in the drilling logbook.

M 2. Blow not reported to the EUB Field Centre immediately.

16.3.4 Blowout—Recording and Reporting

U 1. Blowout not recorded in the drilling logbook.

M 2. Blowout not reported to the EUB Field Centre immediately.

16.4 Deviation Surveys

U 1. Deviation surveys not conducted as required.

U 2. Records of deviation surveys not available.

16.5 Directional Surveys—Critical Sour Wells

U 1. Directional surveys not conducted as required.

U 2. Records of directional surveys not available.

16.6 Well Licence Posting

S 1. Well being drilled without a valid EUB well licence.

U 2. Well licence not posted.

17. Licensee and Contractor Inspections

17.1 Daily Inspections

U 1. Daily inspections not conducted.

17.1.1 Recording Inspections

U 1. Daily inspections not recorded.

17.2 Detailed Inspections

U 1. Detailed inspections not conducted as required.

U 2. EUB Field Centre not contacted 48 hours prior to conducting detailed inspections (critical sour wells).

17.2.1 Recording Inspections

U 1. Detailed inspections not recorded.

18. Well-Site Fluids and Environment

18.1 Invert Mud Systems

U 1. Make-up reserve for invert mud system located within 25 m of the wellbore.

U 2. Make-up reserve for invert mud system located within 50 m of a flare pit/tank, and/or incinerator, and/or burn pit.

18.2 Crude Oil Used to Release Stuck Pipe (Spotting)

U 1. Crude oil used for spotting not dead oil and/or contains H_2S.

18.3 Oil Storage Tanks

U 1. Oil storage tank not located 50 m from the wellbore, and/or flare pit/tank, and/or incinerator, and/or burn pit.

18.4 Temporary Aboveground Storage Tank Diking Requirements

U 1. Temporary aboveground storage of fluids produced or stored does not meet requirements.

18.5 Sump Construction

U 1. Sump construction does not meet minimum requirements.

18.7 Containment of Fluids and Spills

M 1. Fluids not properly contained (spilled off lease).

U 2. Fluids not properly contained (spilled on lease).

M 3. Spill on lease (in excess of 2 m^3) and/or any spill off lease not reported to the EUB.

U 4. Landowner not advised of spill off lease or significant (in excess of 2 m^3) spill on lease.

18.8 Noise Emissions

U 1. Drilling operations exceed permissible sound levels.

18.9 Odourous Emissions

M 1. Emissions/odours off lease.

18.10 Waste Management

18.10.1 Characterization

U 1. Information not readily available to show proper characterization and/or volume of waste generated on site.

18.10.2 Storage

U 1. Waste generated on site not properly stored.

U 2. All waste not removed after the completion of drilling operations.

U 3. Information not readily available to show proper storage, handling, and volume of all waste generated on site.

18.10.3 Disposal

U 1. Waste material generated on site not disposed of in an approved manner.

18.10.3.1 Accounting and Documentation

U 1. Records not readily available to show the source, volume, and final disposition of all waste generated on site.

19. Underbalanced Drilling

S/M/U 1. Underbalanced drilling operation does not meet the minimum requirements set out in *ID 94-3: Underbalanced Drilling.*

20. Oil Sands Core Holes and Evaluation Wells

20.1 Surface Mineable Areas

M 1. Conductor pipe not set into a competent formation.

M 2. Diverter system not installed or not operable.

U 3. Sufficient heat not provided to ensure proper operation of diverter system.

U 4. Diverter system not mechanically tested daily.

U 5. Diverter line does not terminate a minimum of 15 m away from the wellbore.

U 6. Diverter line not adequately secured.

U 7. The mud tank or pit not located a minimum of 2 m from the wellbore.

M 8. Stabbing valve (or similar device) not provided.

M 9. Stabbing valve and associated tools not operable and/or readily accessible.

U 10. Stabbing valve in closed position.

M 11. Crossover subs (if required for the stabbing valve) not provided.

M 12. Equipment inadequate to shut off any flow through the inside of the drill string (wireline coring operations).

M 13. Hole not kept full of drilling mud during coring or tripping operations.

U 14. Engine shut off devices not provided or not operable (within 15 m of the wellbore).

U 15. Core shacks, doghouses, etc., do not have two doors and/or the doors do not open out from the wellbore (within 15 m of the wellbore).

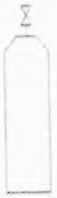
U 16. Open flame and/or other sources of ignition located within 15 m of the wellbore.

U 17. Winter shrouding surrounding the wellbore not open at the top and/or bottom.

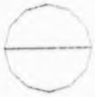
M 18. Crew training inadequate.

M 19. Person with a valid PITS Second-Line Supervisor's Certificate not readily available.

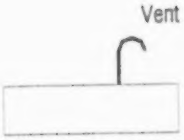
Appendix 2 Equipment Symbols



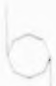
Nitrogen bottle



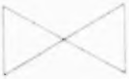
Accumulator



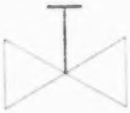
Hydraulic oil reservoir



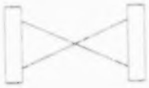
Charge pump



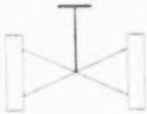
Threaded valve



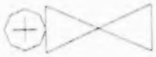
Threaded hydraulic valve



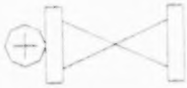
Flanged valve



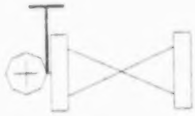
Flanged hydraulic valve



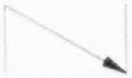
Threaded manual choke



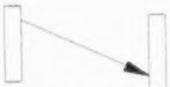
Flanged manual choke



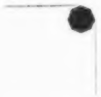
Flanged remote choke



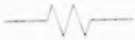
Threaded check valve



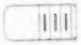
Flanged check valve



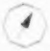
Pop valve



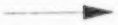
Shock hose



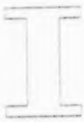
Bull plug



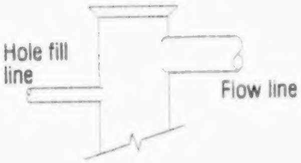
Pressure gauge



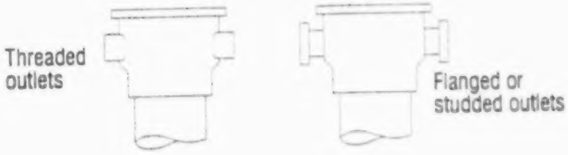
Flow direction



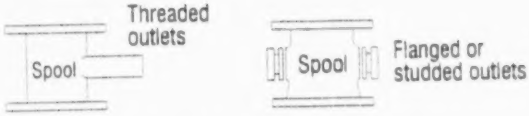
Lubricator


Hole fill line
Flow line

Flow tee


Threaded outlets
Flanged or studded outlets

Casing bowls


Threaded outlets
Spool
Spool
Flanged or studded outlets

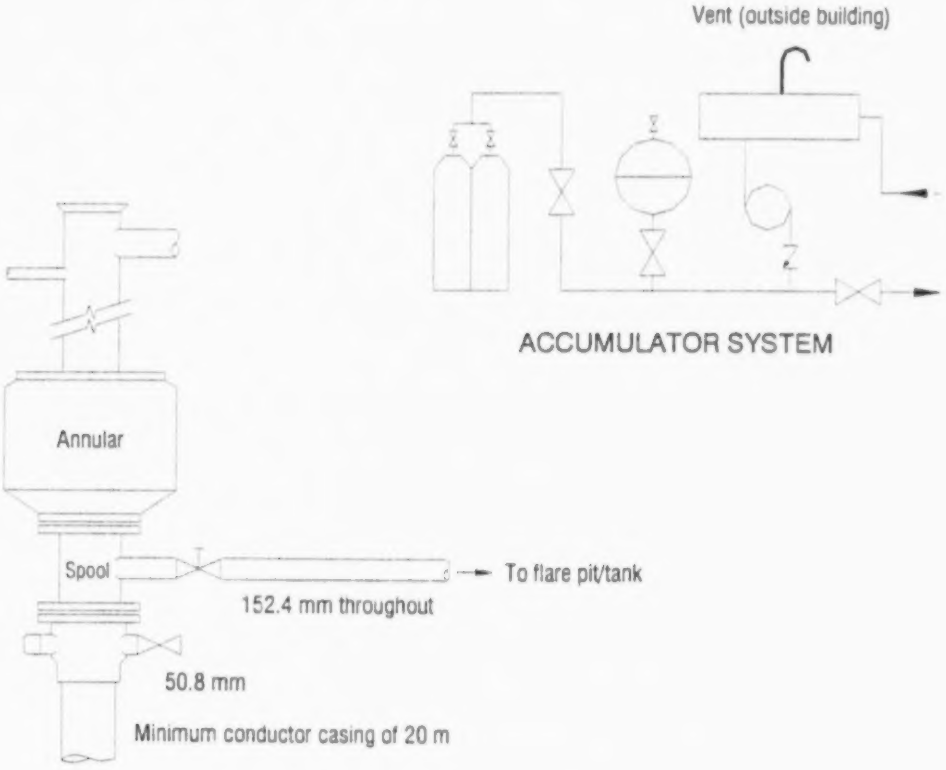
Spools

Appendix 3 Blowout Preventer Systems

Class I—minimum pressure rating 3500 kPa

Drilling blowout prevention systems for

- wells without surface casing set terminating in the Upper Cretaceous (i.e., above the Viking Zone) and/or not exceeding a true vertical depth of 750 m
- heavy oil/oil sands wells where a surface casing reduction has been approved
- wells where surface casing is required to be set at a depth greater than 450 m
- wells where hydrocarbon-bearing formations may be encountered above the required surface casing setting depth


Vent (outside building)
ACCUMULATOR SYSTEM
Annular
Spool
To flare pit/tank
152.4 mm throughout
50.8 mm
Minimum conductor casing of 20 m

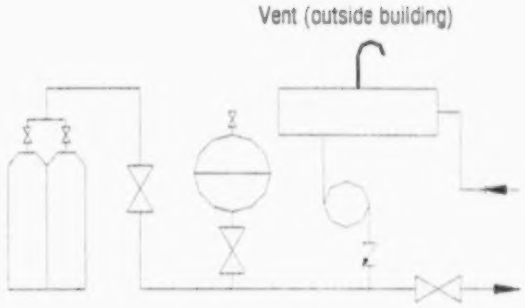
BLOWOUT PREVENTION STACK

Note:

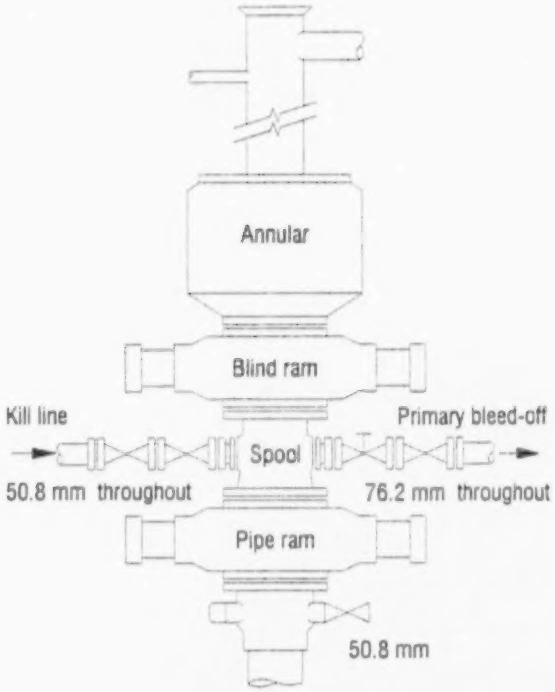
1. The diverter line must be a minimum nominal diameter of 152 mm throughout.
2. See Appendix 2 for equipment symbols.

Class II—minimum pressure rating 7000 kPa

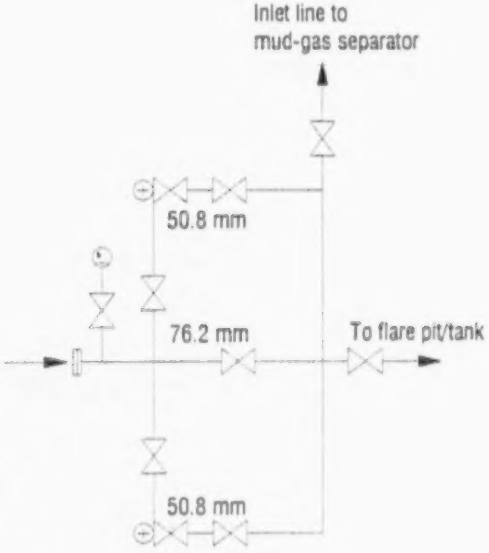
Drilling blowout prevention systems for wells not exceeding a true vertical depth of 750 m


Vent (outside building)

ACCUMULATOR SYSTEM


Annular
Blind ram
Kill line
Primary bleed-off
Spool
50.8 mm throughout
76.2 mm throughout
Pipe ram
50.8 mm

BLOWOUT PREVENTION STACK


Inlet line to
mud-gas separator
50.8 mm
76.2 mm
To flare pit/tank
50.8 mm

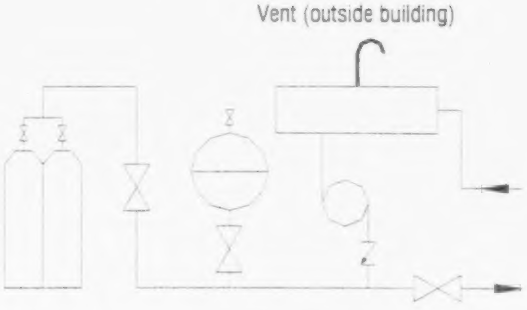
CHOKE MANIFOLD

Note:

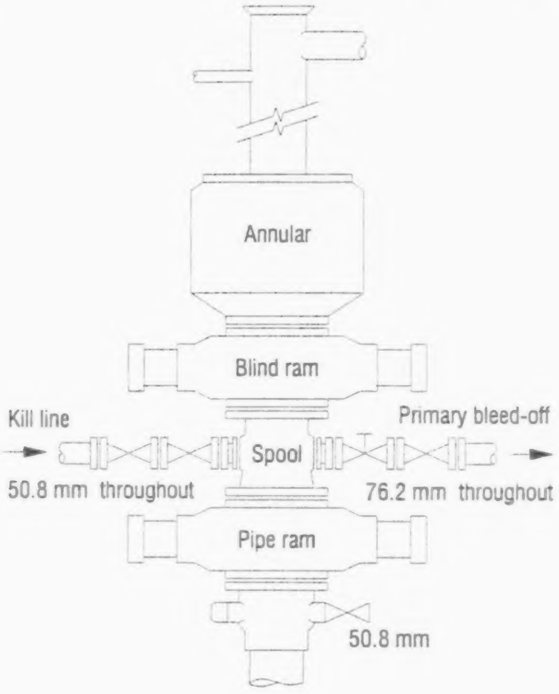
1. Bleed-off line, centreline through choke manifold, and flare line must be a minimum nominal diameter of 76.2 mm throughout.
2. Lines through chokes must be a minimum nominal diameter of 50.8 mm throughout.
3. Kill line must be a minimum nominal diameter of 50.8 mm throughout.
4. Flanged pipe connections must be used from the drilling spool down to and including the connection to the choke manifold. The remainder of the choke manifold may contain threaded fittings.
5. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
6. See Appendix 2 for equipment symbols.

Class III—minimum pressure rating 14 000 kPa

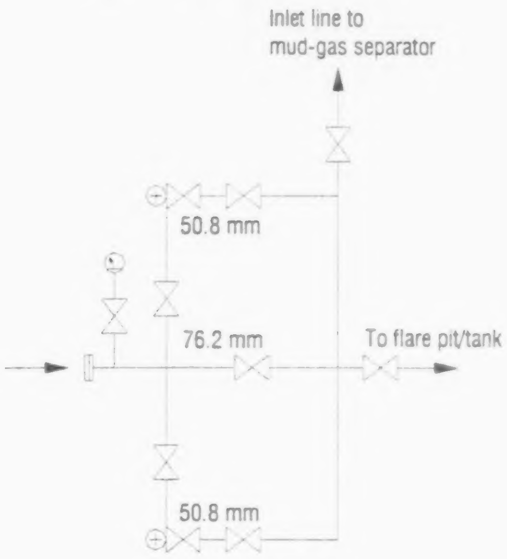
Drilling blowout prevention systems for wells not exceeding a true vertical depth of 1800 m


Vent (outside building)

ACCUMULATOR SYSTEM


Annular
Blind ram
Kill line
Primary bleed-off
Spool
50.8 mm throughout
76.2 mm throughout
Pipe ram
50.8 mm

BLOWOUT PREVENTION STACK


Inlet line to
mud-gas separator
50.8 mm
76.2 mm
To flare pit/tank
50.8 mm

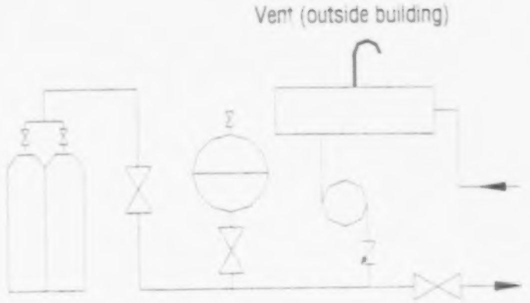
CHOKE MANIFOLD

Note:

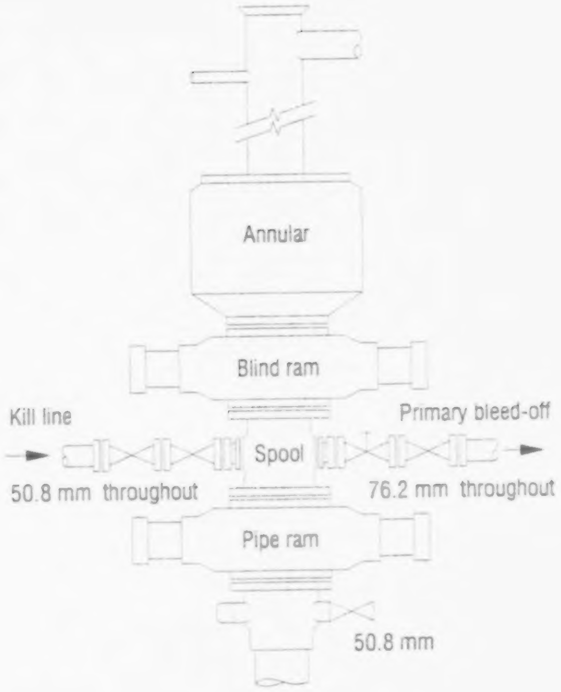
1. Bleed-off line, centreline through choke manifold, and flare line must be a minimum nominal diameter of 76.2 mm throughout.
2. Lines through chokes must be a minimum nominal diameter of 50.8 mm throughout.
3. Kill line must be a minimum nominal diameter of 50.8 mm throughout.
4. Flanged pipe connections must be used from the drilling spool down to and including the connection to the choke manifold. The remainder of the choke manifold may contain threaded fittings.
5. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
6. See Appendix 2 for equipment symbols.

Class IV—minimum pressure rating 21 000 kPa

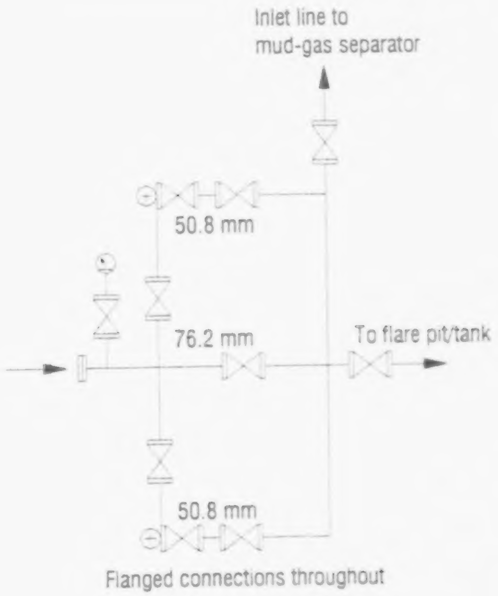
Drilling blowout prevention systems for wells not exceeding a true vertical depth of 3600 m


Vent (outside building)

ACCUMULATOR SYSTEM


Annular
Blind ram
Kill line
Primary bleed-off
Spool
50.8 mm throughout
76.2 mm throughout
Pipe ram
50.8 mm

BLOWOUT PREVENTION STACK


Inlet line to mud-gas separator
50.8 mm
76.2 mm
To flare pit/tank
50.8 mm
Flanged connections throughout

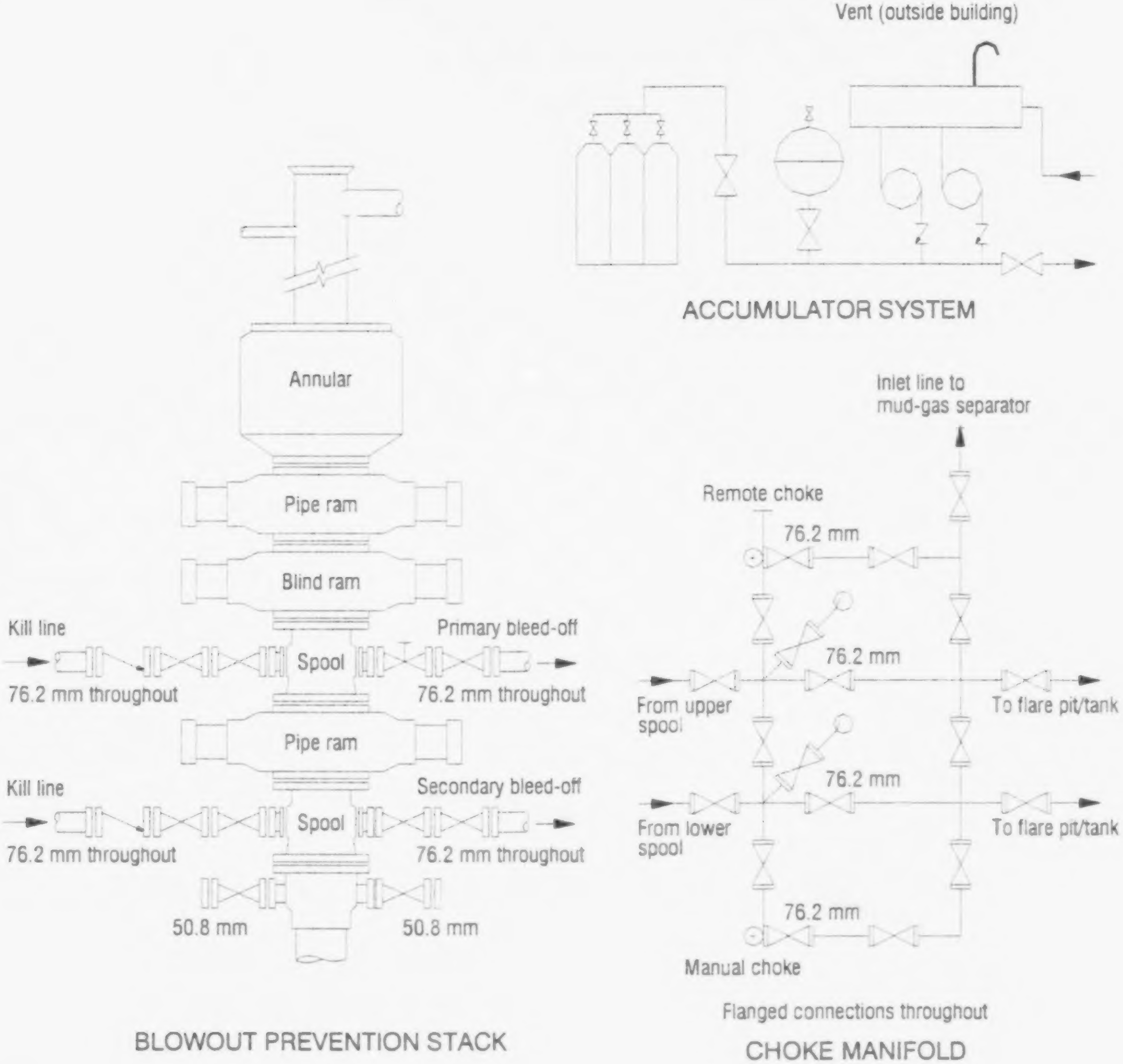
CHOKE MANIFOLD

Note:

1. Bleed-off line, centreline through choke manifold, and flare line must be a minimum nominal diameter of 76.2 mm throughout.
2. Lines through chokes must be a minimum nominal diameter of 50.8 mm throughout.
3. Kill line must be a minimum nominal diameter of 50.8 mm throughout.
4. Flanged pipe connections must be used from the drilling spool to the last valve on the choke manifold, inclusive.
5. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
6. See Appendix 2 for equipment symbols.

Class V—minimum pressure rating 34 000 kPa

Drilling blowout prevention systems for wells not exceeding a true vertical depth of 6000 m


Vent (outside building)
ACCUMULATOR SYSTEM
Annular
Pipe ram
Blind ram
Kill line
76.2 mm throughout
Spool
Primary bleed-off
76.2 mm throughout
Pipe ram
Kill line
76.2 mm throughout
Spool
Secondary bleed-off
76.2 mm throughout
50.8 mm
50.8 mm
Inlet line to mud-gas separator
Remote choke
76.2 mm
76.2 mm
From upper spool
To flare pit/tank
76.2 mm
From lower spool
To flare pit/tank
76.2 mm
Manual choke

BLOWOUT PREVENTION STACK

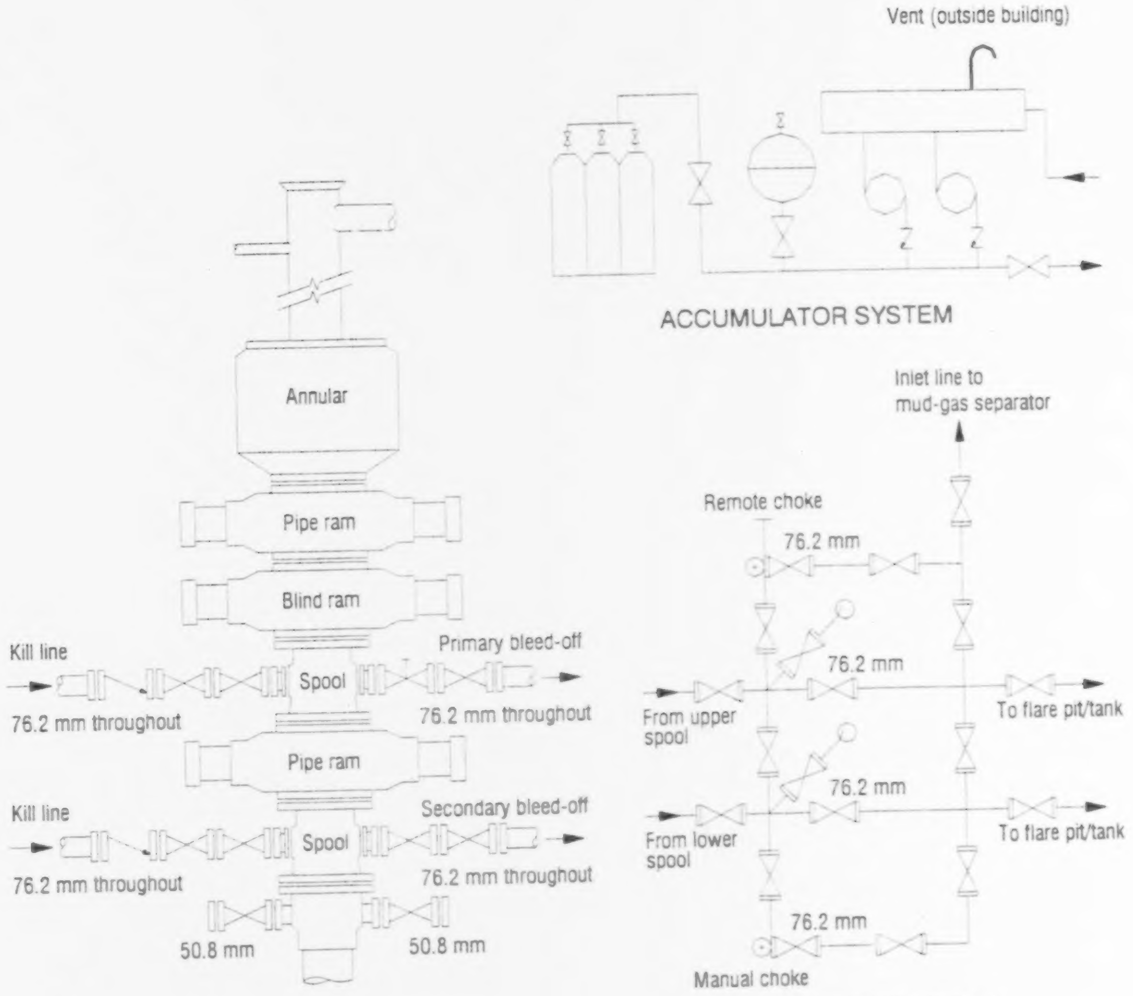
Flanged connections throughout

CHOKE MANIFOLD

Note:
1. Kill lines, bleed-off lines, choke manifold, and flare lines must be a minimum nominal diameter of 76.2 mm throughout.
2. Flanged pipe connections must be used from the drilling spool to the last valve on the choke manifold, inclusive.
3. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
4. For optional BOP stack configurations, see Figure 5: BOP stack configurations—critical sour wells.
5. See Appendix 2 for equipment symbols.

Class VI—minimum pressure rating 69 000 kPa

Drilling blowout prevention systems for wells exceeding a true vertical depth of 6000 m


Vent (outside building)
Annular
Pipe ram
Blind ram
Kill line
76.2 mm throughout
Spool
Primary bleed-off
76.2 mm throughout
Pipe ram
Kill line
76.2 mm throughout
Spool
Secondary bleed-off
76.2 mm throughout
50.8 mm
50.8 mm
Inlet line to
mud-gas separator
Remote choke
76.2 mm
76.2 mm
From upper
spool
To flare pit/tank
76.2 mm
From lower
spool
To flare pit/tank
76.2 mm
Manual choke

ACCUMULATOR SYSTEM

Flanged connections throughout

CHOKE MANIFOLD

BLOWOUT PREVENTION STACK

Note:

1. Kill lines, bleed-off lines, choke manifold, and flare lines must be a minimum nominal diameter 76.2 mm throughout.
2. Flanged pipe connections must be used from the drilling spool to the last valve on the choke manifold, inclusive.
3. Hydraulic and manual valve positions in the bleed-off line are interchangeable.
4. For optional BOP stack configurations, see Figure 5: BOP stack configurations—critical sour wells.
5. See Appendix 2 for equipment symbols.

Appendix 4 NACE Requirements for Metallic Materials Exposed to H_2S

The information provided in this appendix, including Figure 14, is from the current edition of *NACE MR0175*.

Sulphide stress cracking is affected by the following factors:

- metal composition, strength, heat treatment and microstructure;
- hydrogen ion concentration (pH) of the environment;
- H_2S concentration and total pressure;
- total tensile stress (applied plus residual);
- temperature; and
- time.

NACE states that its standard applies to all components of equipment exposed to sour environments where failure by sulphide stress cracking would

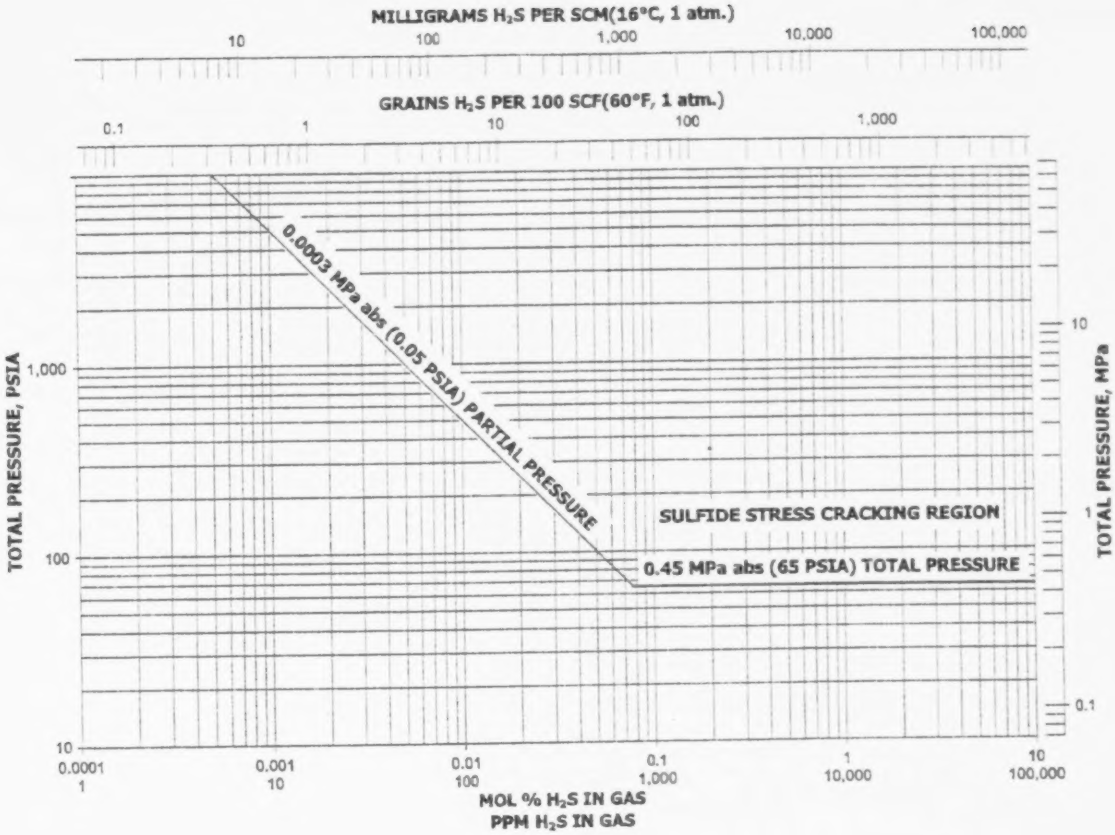
- prevent the equipment from being restored to an operating condition while continuing to contain pressure, and/or
- compromise the integrity of the pressure-containment system, and/or
- prevent the basic function of the equipment from occurring.

A sour environment (as defined by NACE) exists when the partial pressure of H_2S in a wet (water as a liquid) gas phase of a gas or gas condensate or in crude oil is equal to or exceeds 0.34 kPa (abs).

Figure 14 graphically defines a sour environment. If the H_2S concentration and pressure plot into the sulphide stress cracking region of the graph, careful attention should be given to the control of the drilling fluid environment (to neutralize the H_2S) and consideration should be given to the use of equipment that meets NACE standards for metallic materials.

For critical sour wells, all pressure-containing components within the BOP, bleed-off, and kill systems must meet *NACE MR0175* standards.

For further information, refer to *NACE MR0175* (current edition).



Note: 1 kPa = 0.145089 psi

© 2002 by NACE International. All rights reserved by NACE: reprinted by permission. NACE standards are revised periodically. Users are cautioned to obtain the latest edition; information in an outdated version of the standard may not be accurate.

Figure 14. Sour gas systems

Appendix 5 Shop Servicing and Testing of BOP Equipment and Flexible Bleed-off and Kill Line Hoses

Three-Year Certification Requirements

- All BOP equipment (including associated drill-through spools) and flexible bleed-off and kill line hoses used during drilling operations must be shop serviced and pressure tested at least once every three years from the **in-service date**. The **in-service date** is defined as the day the BOP equipment and flexible bleed-off and kill line hoses are placed in service after the certification process (see storage requirements below).

- Three years after the **in-service date,** the BOP equipment and flexible bleed-off and kill line hoses must be taken out of service and sent to a qualified BOP repair facility for certification.

- Prior to expiry of the three-year **in-service date,** BOP equipment and flexible bleed-off and kill line hoses must be recertified prior to being put back into service if they have been subjected to
  - an uncontrolled flow (blowout) of reservoir fluid,
  - pressures in excess of the manufacturers rating,
  - a sour fluid exposure (where the equipment is not *NACE MR0175* certified), or
  - a serious kick or a well control operation of extended duration.

- BOP equipment and flexible bleed-off and kill line hoses must not be placed on a well where the drilling program for the well would exceed the certification expiry date. However, certification would remain in effect for well operations in progress after the three-year expiry period if unforeseen hole problems were encountered. This extended duration must not exceed 30 days without approval from EUB Well Operations in Calgary.

Personnel Qualifications and Documentation

Qualified repair personnel, as described below, must supervise or perform all repairs for the three-year BOP equipment and flexible bleed-off and kill line hose certification.

The Certifying Professional Engineer (P.Eng.) is an engineer who must have
- previous experience or training in repair of pressure vessel and pressure control equipment,
- a practical working knowledge of BOP equipment,
- experience with general quality control standards, and
- professional status in Alberta.

The Certifying P.Eng. will approve or provide inspection and repair methods, as well as approve the quality control procedure to ensure that the repairs are completed as required and adhere to applicable API, ASME, and AWS standards.

Personnel who perform BOP repairs must have
- knowledge of working principles of the BOP equipment,
- mechanical competency in the disassembly, repair, and reassembly of the equipment type and model, and

- training through in-house programs, Original Equipment Manufacturer (OEM) training, or previous on-the-job training under supervision in facilities that provide a similar service or are otherwise approved by the Certifying P.Eng.

Welders must hold a Journeyman Welding Ticket with a "B" Pressure endorsement and should have experience in BOP repair or as specified by the OEM or certifying P.Eng.

Non-Destructive Testing (NDT) Personnel must have a minimum of a Canadian General Standards Board (CGSB) Level II NDT Certification, or as required by the OEM or certifying P.Eng. They should also have prior experience in the inspection of BOPs.

The Certifying Party must be an OEM designated representative, a Certifying P.Eng., or a designated person with industry experience approved by a Certifying P.Eng.

Shop Servicing Requirements

The following procedures are the minimum requirements for shop servicing BOP equipment (and flexible bleed-off and kill line hoses where applicable):

- All mechanical and hydraulic components must be completely disassembled and cleaned.
- During disassembly, an identification system must be employed so that all of the unit's component parts are traceable.
- The received condition of the BOP equipment and all repairs required must be recorded.
- Each component must have written specifications for acceptable condition approved by the OEM or a Certifying P.Eng.
- All wearing components must be measured with calibrated and traceable measuring and testing instruments, and the measurements recorded.
- Non-Destructive Testing (NDT) must be performed and recorded by an individual with a minimum CGSB Level II (according to OEM specifications or a P.Eng.'s written procedure).
- Each component repaired must have written inspection criteria, sizes, tolerance, and part numbers, as well as written repair methods, including welding procedures, heat treatment, and parts standards approved by the OEM or a Certifying P.Eng. Reference must be made to the appropriate API, ASME, and AWS standards. All repairs completed must be clearly identified on the repair report.
- All elastomers must be replaced, with the exception of the annular packing elements and ram rubbers, which are at the discretion of the "certifying party." (Certifying party is defined as an OEM-designated representative, a certifying P.Eng., or a designated person with industry experience approved by a P.Eng.)
- Parts replaced or added to the BOP equipment, including elastomers, must be traceable and designed for the purpose with equivalent or superior performance and must be approved by the OEM or a Certifying P.Eng. All parts replaced are to be clearly identified on the repair report.

Pressure Testing Requirements

All BOP equipment must be completely assembled, function tested, and pressure tested. These tests must be completed and recorded on the final certification before shipment:

- Closed preventer tests must be performed at low- and high-pressure with the low-pressure test always preceding the high-pressure test.
- A low-pressure test of 1400 kPa must be applied and held below the closed preventer (rams/annular packing unit).
- A high-pressure test at least equal to the rated working pressure of the preventer must be applied and held below the closed preventer (rams/annular packing unit).
- An opened and closed function hydraulic chamber pressure test must be performed to the manufacturer's hydraulic system rating.
- All pressure tests are to be held for a 15-minute duration.
- Additional pressure tests must be conducted (if required by the OEM or the certifying P.Eng.).

All flexible bleed-off and kill line hoses must be pressure tested to their rated working pressure for a 15-minute duration.

Storage Requirements

It is acceptable to store BOP equipment and flexible bleed-off and kill line hoses after certification prior to their being placed in service. The BOP equipment and flexible bleed-off and kill line hoses must be properly stored according to OEM standards or a Certifying P.Eng.'s specifications.

If the storage period exceeds one year, the **in-service date** is the date that the BOP equipment and flexible bleed-off and kill line hoses were certified.

Documentation must be available to confirm proper storage.

Documentation

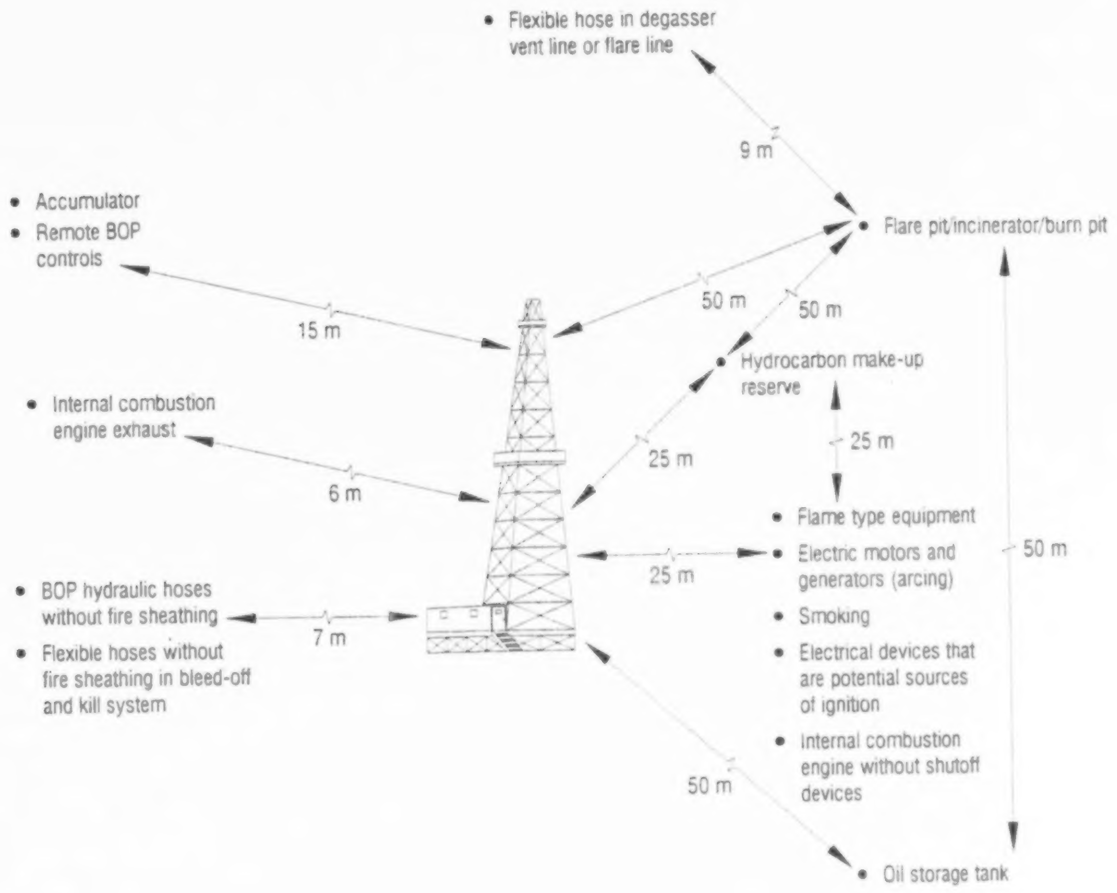
Documentation consists of inspection, repair, and testing reports that have been reviewed and signed off by the certifying party. The certification of a BOP must be retained in a file system containing a copy of the records and repair history keyed to a unique identification number.

A copy of the certification document must be available at the rig site and contain, as a minimum, the following information:

- date of certification and the *in-service* date;
- facility where certification was completed, including work order or job number;
- manufacturer, model, pressure rating, bore size, and serial number of equipment; and
- signature of certifying party.

The EUB acknowledges the Canadian Association of Oilwell Drilling Contractors (CAODC) for their contribution to the revision of the EUB's Three-Year Shop Servicing and Testing Requirements. Further information can be obtained in CAODC's Recommended Practice 6.0 – Blowout Preventer Inspection and Certification.

Appendix 6 Well-Site Spacing—Minimum Distance Requirements


Flexible hose in degasser vent line or flare line
9 m
Flare pit/incinerator/burn pit
Accumulator
Remote BOP controls
15 m
50 m
50 m
Hydrocarbon make-up reserve
25 m
Internal combustion engine exhaust
6 m
25 m
Flame type equipment
Electric motors and generators (arcing)
Smoking
Electrical devices that are potential sources of ignition
Internal combustion engine without shutoff devices
25 m
50 m
BOP hydraulic hoses without fire sheathing
Flexible hoses without fire sheathing in bleed-off and kill system
7 m
50 m
Oil storage tank

Appendix 7 Accumulator Sizing Calculations

Accumulator Sizing—Method 2

Accumulator sizing calculations are performed to determine if the accumulator can provide sufficient usable hydraulic fluid[*] at a minimum pressure of 8400 kPa (or for CTUs and critical sour wells with shear rams, the minimum final pressure required to shear the drill pipe, whichever is greater) to effectively close the required BOP components, open the hydraulically operated valve (HCR) on the bleed-off line, and operate any additional BOP equipment in use with the accumulator recharge pump turned off.

Method Basis

An accumulator's volume of usable[*] fluid is equal to the volume of hydraulic fluid expelled as the pressure is reduced from the operating pressure (accumulator) to the final pressure. The reduction in pressure causes the gas cap to expand, which expels the hydraulic fluid.

The gas used to pressurize the accumulator is assumed to function as an ideal gas.

To Determine Usable Accumulator Hydraulic Fluid Volume at a Pressure Above 8400 kPa

P = pressure
P_{PRE} = precharge pressure
P_{OP} = accumulator operating pressure
P_F = accumulator final pressure
V = volume
V_{OP} = gas volume at operating condition
V_{TOT} = total bottle volume
V_F = gas volume at final condition
V_{USABLE} = usable volume above 8400 kPa
V_{PRE} = initial pressure, $V_{TOT} = V_{PRE}$

1) From the Ideal Gas Law, the following pressure (P), fluid volume (V) relations are known:

$$V_{PRE}\,P_{PRE} = V_{OP}\,P_{OP} = V_F P_F$$

2) By definition:

$$V_{TOT} = V_{PRE}$$

Therefore:

$$V_{OP} = \frac{V_{TOT}\,P_{PRE}}{P_{OP}} \qquad V_F = \frac{V_{TOT}\,P_{PRE}}{P_F}$$

---

[*] Usable fluid is the amount of fluid stored in the accumulator at a minimum pressure of 8400 kPa.

3) The hydraulic fluid volume (F) is the total volume minus the volume occupied by the gas:

$F_{OP} = V_{TOT} - V_{OP}$ $\qquad$ $F_F = V_{TOT} - V_F$

4) The usable fluid (V_{USABLE}) available is the difference between the fluid available at operation conditions and final conditions:

$$V_{USABLE} = F_{OP} - F_F$$

$$= V_F - V_{OP}$$

$$= \frac{V_{TOT}\, P_{PRE}}{P_F} - \frac{V_{TOT}\, P_{PRE}}{P_{OP}}$$

$$= V_{TOT}\, P_{PRE}\, (1/P_F - 1/P_{OP})$$

The usable fluid available is equal to the accumulator volume multiplied by the precharge pressure multiplied by the difference between the reciprocals of the final pressure and the operating pressure.

Calculation Formula

V_{USABLE} = Accumulator Volume x Precharge Pressure x (1/Fin Pres – 1/Op Pres)

SAMPLE CALCULATION 1

Rig Specifications

Accumulator Data:

51.6 litre accumulator with
21.0 MPa operating pressure
7.0 MPa precharge pressure

BOP Data:

254 mm 21 MPa Hydril GK annular BOP
254 mm 21 MPa Hydril manual lock pipe rams[*]
101.6 mm 21 MPa Cameron HCR hydraulic valve

Calculation Formula

Since the minimum final[**] pressure required is 8400 kPa (8.4 MPa),

V_{USABLE} = Accumulator Volume x Precharge Pressure x (1/8.4 MPa – 1/Op MPa)

---

[*] If precharge is greater than 8.4 MPa, final pressure must equal precharge pressure.

[**] If two sets of pipe rams are required, the closing volume for each set must be included in the calculations.

Step 1:

V_{USABLE} = Accumulator Volume x Precharge Pressure x (1/8.4 MPa – 1/Op MPa)

V_{USABLE} = 151.6 litres x 7.0 MPa x (1/8.4 MPa – 1/21 MPa)
= 151.6 litres x 7.0 x 0.07143
= **75.8 litres**

Step 2:

Determine fluid volume needed to function preventers (see Appendix 9).

Volume to close annular = 28.1 litres
Volume to close pipe rams = 12.5 litres
Volume to open hydraulic valve = 2.0 litres

Total volume = **42.6 litres**

Conclusion

The accumulator is adequate because 75.3 litres of usable fluid is available (above 8400 kPa), when only 42.6 litres of fluid is needed to activate the BOP components.

SAMPLE CALCULATION 2—FOR CRITICAL SOUR WELLS

Rig Specifications

Drill Pipe:

114.3 mm 16.5 kg/m E grade drill pipe

Accumulator Data:

795 litre accumulator with
21.0 MPa operating pressure
7.0 MPa precharge pressure

BOP Data:

103 mm 34 MPa Shaffer Floseal HCR hydraulic valve
343 mm 34 MPa Hydril GK annular BOP
343 mm 34 MPa Shaffer SL manual lock pipe rams (2 sets)
343 mm 34 MPa Shaffer LWS posi lock shear/blind ram (these rams require a minimum final accumulator operating pressure of 10 MPa to shear 114.3 mm grade E drill pipe)

Calculation Formula

V_{USABLE} = Accumulator Volume x Precharge Pressure x (1/Fin Pres – 1/Op Pres)

The minimum final pressure required to shear 114.3 mm grade E drill pipe with 343 mm 34 MPa Shaffer LWS posi lock shear/blind ram is 10 MPa; therefore, the final operating pressure cannot be less than 10 MPa.

Note that pressures required to shear drill pipe vary, depending on drill pipe in use and the make and model of shear ram.

V_{USABLE} = Accumulator Volume x Precharge Pressure x (1/10 MPa – 1/Op MPa)

Step 1:

V_{USABLE} = Accumulator Volume x Precharge Pressure x (1/10 MPa – 1/Op MPa)

V_{USABLE} = 795 litres x 7.0 MPa x (1/10 MPa – 1 /21 MPa)
= 795 litres x 7.0 x .052381
= 291.5 litres

Step 2:

Determine fluid volume needed to operation the preventers (see Appendix 9).

Volume to open hydraulic valve	= 3.0 litres
Volume to close annular	= 68.1 litres
Volume to close pipe ram	= 16.5 litres
Volume to open pipe ram	= 20.1 litres
Volume to close pipe ram	= 16.5 litres
Volume to close blind/shear ram	= 40.0 litres
Total required volume	**= 164.2 litres**

Conclusion

The accumulator is adequate because 291.5 litres of usable fluid is available (above 10 MPa), when only 164.2 litres of fluid is needed to activate the BOP components and shear the drill pipe.

Appendix 8 Nitrogen Sizing Calculations

Nitrogen Sizing— Method 2

Nitrogen (N_2) sizing calculations are conducted to determine if the backup N_2 system can provide sufficient usable N_2 at a minimum pressure of 8400 kPa (or for CTUs and critical sour wells with shear rams, the minimum final pressure required to shear the drill pipe, whichever is greater) to effectively close the required BOP components, open the HCR on the bleed-off line, and operate any additional BOP equipment in use with the accumulator isolated.

Method Basis

A N_2 bottle's volume of usable fluid is equal to the volume of gas expelled as the pressure is reduced from the operating pressure, causing the gas to expand into the BOP closing system.

N_2 is assumed to function as an ideal gas.

To Determine Usable Backup N_2 Fluid Volume at a Pressure Above 8400 kPa

P = pressure
P_{OP} = accumulator operating pressure
P_F = accumulator final pressure
V = volume
V_{OP} = gas volume at operating condition
V_{TOT} = total bottle volume
V_F = gas volume at final condition
V_{USABLE} = usable volume above 8400 kPa

1) From the Ideal Gas Law, the following pressure (P) volume is known:

$$P_{OP} V_{OP} = P_F V_F$$

or

$$\frac{V_F}{V_{OP}} = \frac{P_{OP}}{P_F}$$

2) The gas volume at operating conditions (V_{OP}) fills the bottle volume (V_{TOT}):

$$V_{OP} = V_{TOT}$$

The gas volume at final conditions (V_F) fills the bottle and enters the BOP closing system (V_{USABLE}):

$$V_F = V_{TOT} + V_{USABLE}$$

3) Substituting:

$$\frac{V_{TOT} + V_{USABLE}}{V_{TOT}} = \frac{P_{OP}}{P_F}$$

$$V_{USABLE} = V_{TOT}\left[\frac{P_{OP}}{P_F} - 1\right]$$

If all bottles are the same size, then an average pressure may be used (see Section 6, Figure 2, for bottle dimensions).

$$P_{OP} = \frac{P_1 + P_2 + \ldots}{\#N_2 \text{ bottles}}$$

and the total number of N_2 bottles must be used.

$$V_{TOT} = V_1 + V_2 + \ldots$$

If all bottles are not the same size, V_{USABLE} must be calculated for each bottle and totalled for the system.

Calculation Formula

$$V_{USABLE} = V_{TOT}\left[\frac{P_{OP}}{P_F} - 1\right]$$

SAMPLE CALCULATION 1

Rig Specifications

Accumulator Data:

Two 42-litre N_2 bottles @
17.5 MPa and 14.0 MPa

BOP Data:

254 mm 21 MPa Hydril GK annular BOP
254 mm 21 MPa Hydril manual lock pipe rams*
101.6 mm 21 MPa Cameron HCR hydraulic valve

---

* Calculations must include the closing volume for two sets of rams if well classification requires two sets of pipe rams.

Calculation Formula

$$V_{USABLE} = V_{TOT}\left[\frac{P_{OP}}{P_{F}} - 1\right]$$

Since the minimum final pressure required is 8400 kPa (8.4 MPa),

$$V_{USABLE} = V_{TOT}\left[\frac{P_{OP}}{8.4\ \text{MPa}} - 1\right]$$

Step 1:

Average pressure of N_2 bottles is $\dfrac{17.5\ \text{MPa} + 14.0\ \text{MPa}}{2\ \text{bottles}}$

= 15.75 MPa

Step 2:

Total N_2 volume available is V_{TOT} = 42 litres + 42 litres

= 84 litres

Step 3: $V_{USABLE} = 84\ \text{litres}\left[\frac{15.75}{8.4\ \text{MPa}} - 1\right]$

= 73.5 litres

Step 4:

Determine fluid volume needed to operate the preventers (see Appendix 9).

Volume to close annular = 28.1 litres
Volume to close pipe rams = 12.5 litres
Volume to open hydraulic valve = 2.0 litres

Total required volume **= 42.6 litres**

Conclusion

The backup N_2 supply is adequate, since V_{USABLE} (73.5 litres) is greater than the fluid volume required (42.6 litres) to activate the BOP components.

Sample Calculation 2—For Critical Sour Wells

Rig Specifications

Drill Pipe:

114.3 mm 16.5 kg/m grade E drill pipe

Accumulator Data:

Five 50 litre N_2 bottles @
17.5 MPa, 17.5 MPa, 17 MPa, 17 MPa, and 16.5 MPa

BOP Data:

103 mm 34 MPa Shaffer Floseal HCR hydraulic valve
343 mm 34 MPa Hydril GK annular BOP
343 mm 34 MPa Shaffer SL manual lock pipe rams (2 sets)
343 mm 34 MPa Shaffer LWS posi lock shear/blind ram (these rams require a minimum final accumulator operating pressure of 10 MPa to shear 114.3 mm grade E drill pipe)

Calculation Formula

$$V_{USABLE} = V_{TOT} \left[\frac{P_{OP}}{P_F} - 1 \right]$$

The minimum final pressure required to shear 114.3 mm grade E drill pipe with the shear rams in use is 10 MPa; therefore, the final operating pressure cannot be less than 10 MPa.

Note that pressures required to shear drill pipe vary, depending on drill pipe in use and the make and model of shear ram.

$$V_{USABLE} = V_{TOT} \left[\frac{P_{OP}}{10.0\ \text{MPa}} - 1 \right]$$

Step 1:

$$\text{Average pressure of } N_2 \text{ bottles} = \frac{17.5\ \text{MPa} + 17.5\ \text{MPa} + 17\ \text{MPa} + 17\ \text{MPa} + 16.5\ \text{MPa}}{5\ \text{bottles}}$$

= 17.1 MPa

Step 2:

Total N_2 volume available = V_{TOT} = 50 litres x 5 bottles

= 250 litres

Step 3: $$V_{USABLE} = 250\ \text{litres} \left[\frac{17.1\ \text{MPa}}{10\ \text{MPa}} - 1 \right]$$

= 177.5 litres

Step 4:

Determine fluid volume needed to operate the preventers (see Appendix 9).

Volume to open hydraulic valve = 3.0 litres
Volume to close annular = 68.1 litres
Volume to close pipe ram = 16.5 litres
Volume to open pipe ram = 20.1 litres
Volume to close pipe ram = 16.5 litres
Volume to close blind/shear ram = 40.0 litres

Total required volume = **164.2 litres**

Conclusion

The backup nitrogen supply is adequate, since V_{USABLE} (177.5 litres) is greater than the fluid volume required (164.2 litres) to activate the BOP components and shear the drill pipe.

Appendix 9 BOP Fluid Volume Requirements

Bowen Tools Ram-Type BOP

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
51924	64	34000	64	1.4	1.1
51922	64	42000	64	0.6	0.6
60701	64	69000	64	1.6	1.3
51923	64	69000	64	0.7	0.7
50460	65	103400	65	1.1	1.1
51926	76	34000	76	1.1	0.8
51928	76	34000	76	2.0	1.9
51927	76	69000	76	1.1	0.8
51929	76	69000	76	2.0	1.9
61040	102	34000	102	3.4	3.1
61048	102	34000	102	4.5	6.1
61044	102	69000	102	3.4	3.1
61050	102	69000	102	4.5	6.1
47034	103	69000	103	1.6	1.3
60467	103	103400	103	1.6	1.3
61053	114	21000	114	3.4	3.1
61057	114	34000	114	6.9	6.2
61055	114	69000	114	3.4	3.1
61060	114	69000	114	6.9	6.2
51938	140	21000	140	5.7	5.2
63642	179	69000	179	2.8	2.8

Cameron - Ram-Type BOP (manual lock)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
U	152	21000	179	4.9	4.9
U	152	34000	179	4.9	4.9
U	179	69000	179	4.9	4.9
U	179	103400	179	4.9	4.9
U	254	21000	279	12.7	12.1
U	254	34000	279	12.7	12.1
U	279	69000	279	12.7	12.1
U	279	103400	279	12.7	12.1
U	305	21000	346	22.0	20.4
U	346	34000	346	22.0	20.4
U	346	69000	346	22.0	20.4
U	346	103400	346	42.8	44.3
U	425	21000	425	37.1	40.1
U	425	34000	425	37.1	40.1
U	476	69000	476	87.1	94.3
U	508	14000	527	31.8	29.7
U	508	21000	527	31.8	29.7
U	540	14000	540	31.8	29.7
U	540	69000	540	100.3	91.2
U	680	14000	680	39.4	37.3
U	680	21000	680	39.4	37.3
UL	179	21000	179	8.7	8.3
UL	179	34000	179	8.7	8.3
UL	179	69000	179	8.7	8.3
UL	179	103400	179	8.7	8.3
T	346	69000	346	52.6	48.8
QRC	152	21000	179	3.1	3.6
QRC	152	34000	179	3.1	3.6
QRC	203	21000	229	8.9	10.2
QRC	203	34000	229	8.9	10.2
QRC	254	21000	279	10.5	12.0
QRC	254	34000	279	10.5	12.0
QRC	305	21000	346	16.7	19.3
QRC	406	14000	426	22.7	26.7
QRC	457	14000	451	22.7	26.7
QRC	508	14000	527	22.7	26.7
SS	152	21000	179	3.3	2.7
SS	152	34000	179	3.3	2.7
SS	203	21000	229	5.7	4.9
SS	203	34000	229	5.7	4.9
SS	254	21000	279	5.7	4.9
SS	254	34000	279	5.7	4.9
SS	305	21000	346	11.0	9.5
SS	356	34000	346	11.0	9.5

(continued)

Cameron - Ram-Type BOP (manual lock) (continued)					
Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
type F w/type L oper.	152	21000	179	15.0	13.1
type F w/type L oper.	152	34000	179	15.0	13.1
type F w/type L oper.	178	69000	179	15.0	13.1
type F w/type L oper.	178	103400	179	15.0	13.1
type F w/type L oper.	203	21000	229	25.9	23.4
type F w/type L oper.	203	34000	229	25.9	23.4
type F w/type L oper.	254	21000	279	25.9	23.4
type F w/type L oper.	254	34000	279	25.9	23.4
type F w/type L oper.	279	69000	279	25.9	23.4
type F w/type L oper.	305	21000	346	39.0	35.5
type F w/type L oper.	356	34000	346	39.0	35.5
type F w/type L oper.	406	14000	426	44.3	40.4
type F w/type L oper.	406	21000	426	44.3	40.4
type F w/type L oper.	508	14000	540	44.3	40.4
type F w/type L oper.	508	21000	540	44.3	40.4
type F w/type H oper.	152	21000	179	2.0	4.0
type F w/type H oper.	152	34000	179	2.0	4.0
type F w/type H oper.	178	69000	179	2.0	4.0
type F w/type H oper.	178	103400	179	2.0	4.0
type F w/type H oper.	203	21000	229	3.4	6.8
type F w/type H oper.	203	34000	229	3.4	6.8
type F w/type H oper.	254	21000	279	3.4	6.8
type F w/type H oper.	254	34000	279	3.4	6.8
type F w/type H oper.	279	69000	279	3.4	6.8
type F w/type H oper.	305	21000	346	5.6	10.2
type F w/type H oper.	346	34000	346	5.6	10.2
type F w/type H oper.	406	14000	426	6.5	11.7
type F w/type H oper.	406	21000	426	6.5	11.7
type F w/type H oper.	508	14000	540	6.5	11.7
type F w/type H oper.	508	21000	540	6.5	11.7
Type F w/type W_2 oper.	152	21000	179	5.7	8.7
Type F w/type W_2 oper.	152	34000	179	5.7	8.7
Type F w/type W_2 oper.	178	69000	179	5.7	8.7
Type F w/type W_2 oper.	178	103400	179	5.7	8.7
Type F w/type W_2 oper.	203	21000	229	10.6	14.0
Type F w/type W_2 oper.	203	34000	229	10.6	14.0
Type F w/type W_2 oper.	254	21000	279	10.6	14.0
Type F w/type W_2 oper.	254	34000	279	10.6	14.0
Type F w/type W_2 oper.	279	69000	279	10.6	14.0
Type F w/type W_2 oper.	305	21000	346	15.5	20.1
Type F w/type W_2 oper.	356	34000	346	15.5	20.1
Type F w/type W_2 oper.	406	14000	426	18.9	22.7
					(continued)

Cameron - Ram-Type BOP (manual lock) (concluded)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to close
Type F w/type W_2 oper.	**406**	**21000**	**426**	**18.9**	**22.7**
Type F w/type W_2 oper.	508	14000	514	18.9	22.7
Type F w/type W_2 oper.	508	21000	514	18.9	22.7
type F w/type W oper.	152	21000	179	8.7	11.5
type F w/type W oper.	152	34000	179	8.7	11.5
type F w/type W oper.	178	69000	179	8.7	11.5
type F w/type W oper.	178	103400	179	8.7	11.5
type F w/type W oper.	203	21000	229	14.0	17.4
type F w/type W oper.	203	34000	229	14.0	17.4
type F w/type W oper.	254	21000	279	14.0	17.4
type F w/type W oper.	254	34000	279	14.0	17.4
type F w/type W oper.	279	69000	279	14.0	17.4
type F w/type W oper.	305	21000	346	25.7	30.7
type F w/type W oper.	356	34000	346	25.7	30.7
type F w/type W oper.	406	14000	426	7.6	34.4
type F w/type W oper.	406	21000	426	7.6	34.4
type F w/type W oper.	508	14000	540	7.6	34.4
type F w/type W oper.	508	21000	540	7.6	34.4

Cameron - Ram-Type BOP (posi lock)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
T	476	103400	476	92.0	84.8
TL	473	34000	473	68.8	66.0
TL	473	69000	473	76.5	73.4
TL	473	103400	473	92.0	84.8
UII	476	69000	476	93.5	84.4
UII	476	103400	476	131.4	122.3

Cameron - Ram-Type BOP (manual lock shear rams)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
U	152	21000	179	6.4	6.1
U[a]	152	21000	179	12.5	6.1
U	152	34000	179	6.4	6.1
U[a]	152	34000	179	12.5	6.1
U	179	69000	179	6.4	6.1
U[a]	179	69000	179	12.5	6.1
U	179	103400	179	6.4	6.1
U[a]	179	103400	179	12.5	6.1
U[a]	346	34000	346	43.9	41.3
U[a]	346	69000	346	43.9	41.3
U[a]	425	21000	425	40.9	44.3
U[a]	425	34000	425	40.9	44.3
U[a]	508	14000	527	63.6	59.4
UL	179	21000	179	10.2	10.2
UL	179	34000	179	10.2	10.2
UL	179	69000	179	10.2	10.2
UL	179	103400	179	10.2	10.2

[a] Indicates shear ram with booster.

Dreco and Griffith Oil Tool - Ram-Type BOP

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
1531	179	21000	178	2.0	1.5
1101	179	34000	178	2.6	1.9

Dresser OME (Guiberson) - Ram-Type BOP

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
TYPE H HYD CYL	152	21000	187	4.2	3.6
TYPE H HYD CYL	203	14000	230	4.2	3.6

Hydril - Ram-Type BOP (manual lock)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
SENTRY	179	21000	179	1.3	1.2
SENTRY	179	34000	179	1.3	1.2
Hydril	152	21000	179	3.8	4.9
Hydril	152	34000	179	3.8	4.9
Hydril	179	69000	179	7.2	6.8
Hydril	179	103400	179	14.0	12.9
Hydril	203	21000	229	7.2	7.2
Hydril	203	34000	229	7.2	7.2
Hydril	254	21000	279	12.5	12.1
Hydril	254	34000	279	12.5	12.1
Hydril	279	69000	279	19.7	18.9
Hydril	279	103400	279	33.3	30.7
Hydril	304	21000	346	20.4	18.5
Hydril	346	34000	346	20.4	18.2
Hydril	346	69000	346	46.2	43.9
Hydril	476	34000	476	64.7	60.9
Hydril	508	21000	527	30.7	27.3
Hydril	508	14000	539	30.7	27.3
Hydril	539	34000	539	66.2	62.8

Hydril - Ram-Type BOP (posi lock)					
Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
Hydril	152	21000	179	4.5	4.9
Hydril	152	34000	179	4.5	4.9
Hydril	179	69000	179	7.6	6.8
Hydril	179	103400	179	14.8	12.8
Hydril	279	69000	279	21.5	18.9
Hydril	279	103400	279	35.2	30.7
Hydril	279	137800	279	47.3	43.5
Hydril	304	21000	346	22.3	18.5
Hydril	346	34000	346	22.3	19.7
Hydril	346	69000	346	48.5	43.9
Hydril	346	103400	346	47.7	41.6
Hydril	425	69000	425	54.9	53.4
Hydril	476	34000	476	67.8	60.9
Hydril	476	69000	476	64.7	59.1
Hydril	476	103400	476	73.4	42.4
Hydril	508	21000	527	68.1	61.7
Hydril	508	14000	539	68.1	61.7
Hydril	539	34000	539	73.1	62.8

Hydril - Ram-Type BOP (manual lock shear rams)					
Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
Hydril	254	21000	279	20.8	18.9
Hydril	254	34000	279	20.8	28.9
Hydril	279	69000	279	33.3	31.0
Hydril	279	103400	279	33.3	30.7
Hydril	305	21000	346	43.5	42.4
Hydril	346	34000	346	43.5	42.4
Hydril	346	69000	346	46.2	43.9
Hydril	476	34000	476	64.7	60.9
Hydril	508	21000	527	65.1	61.7
Hydril	508	14000	527	65.1	61.7
Hydril	527	34000	537	66.2	62.8

Hydril - Ram-Type BOP (posi lock shear rams)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
Hydril	254	21000	279	22.7	18.9
Hydril	254	34000	279	22.7	18.9
Hydril	279	69000	279	35.2	31.0
Hydril	279	103400	279	35.2	30.7
Hydril	279	137800	279	47.3	43.5
Hydril	305	21000	346	45.4	42.4
Hydril	346	34000	346	45.4	42.4
Hydril	346	69000	346	48.5	43.9
Hydril	346	103400	346	47.7	41.6
Hydril	425	69000	425	59.1	53.4
Hydril	476	34000	476	67.8	60.9
Hydril	476	69000	476	64.7	59.1
Hydril	476	103400	476	73.4	63.2
Hydril	508	21000	527	68.1	61.7
Hydril	508	14000	527	68.1	61.7
Hydril	527	34000	527	73.1	62.8

NL Shaffer - Ram-Type BOP (manual lock)					
Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
LWS	103	34000	103	1.9	1.8
LWS	103	69000	103	1.9	1.8
LWS	152	21000	179	4.5	3.8
LWS	152	34000	179	4.5	3.8
LWS	179	69000	179	24.0	22.3
LWS	179	103400	179	24.0	22.3
LWS	203	21000	229	9.8	8.6
LWS	203	34000	229	9.8	8.6
LWS	229	69000	229	9.2	9.2
LWS	254	21000	279	6.6	5.5
LWS	254	34000	279	11.3	9.9
LWS	279	69000	279	13.7	12.5
LWS	305	21000	346	12.7	11.2
LWS	346	34000	346	12.7	11.2
LWS	346	69000	346	40.1	37.2
LWS	406	21000	425	17.8	15.6
LWS	425	34000	425	25.0	22.8
LWS	508	14000	540	19.2	16.9
LWS	508	21000	540	19.2	16.9
LWP	152	21000	179	2.1	1.9
LWP	203	21000	229	2.9	2.9
SL	279	69000	279	31.2	26.5
SL	279	103400	279	35.5	30.7
SL	346	21000	346	16.5	20.1
SL	346	34000	346	16.5	20.1
SL	346	69000	346	47.8	39.8
SL	346	103400	346	47.8	39.8
SL	425	34000	425	52.9	48.1
SL	425	69000	425	54.8	47.3
B+E	152	21000	179	10.4	8.7
B+E	152	34000	179	10.4	8.7
B+E	203	21000	229	10.4	8.7
B+E	203	34000	229	10.4	8.7
B+E	254	21000	279	12.3	10.2
B+E	254	34000	279	12.3	10.2
B+E	279	69000	279	13.7	12.5
B+E	305	21000	346	13.4	11.0
B+E	356	34000	346	13.4	11.0
B+E	406	14000	394	13.8	11.4
SENTINEL	179	21000	179	2.6	2.1

NL Shaffer - Ram-Type BOP (posi lock)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
LWS	179	103400	179	27.4	25.0
LWS	254	34000	279	18.0	15.8
LWS	279	69000	279	15.9	14.0
LWS	305	21000	346	20.2	17.8
LWS	346	34000	346	20.1	16.7
LWS	425	21000	425	27.4	24.2
LWS	425	34000	425	27.4	24.2
LWS	476	69000	476	57.9	50.0
LWS	508	14000	540	29.5	26.0
LWS	508	21000	540	29.5	26.0

NL Shaffer - Ram-Type BOP (posi lock shear rams)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
LWS	179	69000	179	19.6	19.8
LWS	254	34000	279	35.2	32.1
LWS	279	69000	279	31.1	28.4
LWS	305	21000	346	40.0	36.4
LWS	346	34000	346	40.0	36.4
LWS	346	69000	346	43.8	39.8
LWS	425	34000	425	52.9	48.1
LWS	508	14000	540	63.9	58.1
LWS	508	21000	540	63.9	58.1
LWS	540	52000	540	60.8	52.5
LWS	540	69000	540	60.8	52.5

Shafco - Ram-Type BOP (manual lock)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
RT	179	21000	179	2.6	2.1
RT	179	34000	179	2.6	2.1
NRS or RS	279	21000	279	12.3	10.2
NRS or RS	279	34000	279	12.3	10.2
NRS or RS	346	21000	346	13.4	10.9
NRS or RS	346	34000	346	13.4	10.9

Townsend International (Weatherford) - Ram-Type BOP (manual lock)

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
TYPE '81	179	21000	179	2.6	2.1
TYPE '81	179	34000	179	2.8	2.3
TYPE '81	229	21000	229	2.8	2.3
TYPE '81	229	34000	229	2.8	2.3
TYPE '82	179	34000	179	5.5	4.5
TYPE '82	279	21000	279	6.6	5.5
TYPE '88	229	21000	229	2.9	2.6

Wellsite Specialists Incorporated WSI - Ram-Type BOP

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
Duke	179	21000	179	2.7	2.2

Cameron - Annular Preventers, Diverters, and Strippers

Model or Type	BOP size (MM)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
A	152	34000	179	8.3	7.2
A	152	69000	179	15.1	11.7
A	279	34000	279	29.5	24.6
A	279	69000	279	45.8	39.7
A	346	34000	346	59.7	52.6
A	346	69000	346	81.4	70.8
A	425	34000	425	124.9	109.8
D and DL	179	21000	179	6.4	5.3
D and DL	179	34000	179	6.4	5.3
D and DL	179	69000	179	11.1	9.7
D and DL	179	103400	179	26.3	23.2
D and DL	179	137800	179	31.7	28.6
D and DL	279	21000	279	21.4	17.8
D and DL	279	34000	279	21.4	17.8
D and DL	279	69000	279	38.4	34.3
D and DL	279	103400	279	89.0	80.6
D and DL	346	21000	346	45.9	39.1
D and DL	346	34000	346	45.9	39.1
D and DL	346	69000	346	68.5	61.1
D and DL	425	21000	425	84.4	71.9
D and DL	425	34000	425	84.4	71.9
D and DL	476	34000	476	137.8	109.8
D and DL	476	69000	476	193.1	170.7
D and DL	527	21000	527	153.3	107.5
D and DL	540	14000	540	153.3	107.5

Griffith Oil Tool - Annular Preventers, Diverters, and Strippers					
Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
1100	179	21000	179	14.8	12.7
1100	179	34000	179	14.8	12.7

Hydril - Annular Preventers, Diverters, and Strippers

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
MSP	152	14000	179	10.7	7.5
MSP	203	14000	229	17.3	11.2
MSP	254	14000	279	28.1	19.8
MSP	508	14000	527	117.5	71.7
MSP	508	14000	552	117.5	71.7
MSP	749	3500	749	227.1	N/A
GX	279	69000	279	67.6	67.6
GX	279	103400	279	91.2	91.2
GX	346	34000	346	60.9	60.9
GX	346	69000	346	91.2	91.2
GX	346	103400	346	128.7	128.7
GX	476	69000	476	219.6	219.6
GL	346	34000	346	74.8 [a]	74.8
GL	425	34000	425	133.6 [b]	133.6
GL	425 (dual)	34000	425	166.6 [b]	166.6
GL	476	34000	476	166.6 [c]	166.6
GL	476 (dual)	34000	476	219.5 [c]	219.5
GL	540	34000	540	219.5 [d]	219.5
GK [e]	152	21000	179	10.8	8.5
GK [e]	152	34000	179	10.8	8.5
GK	179	69000	179	35.7	26.8
GK	179	103400	179	42.4	28.4
GK	179	137800	179	41.3	27.3
GK	211 or 203	21000	229	16.4	12.9
GK	212 or 203	34000	229	25.9	22.0
GK	229	69000	229	60.2	45.2
GK	254	21000	279	28.1	21.0
GK	254	34000	279	37.1	30.2
GK	279	69000	279	95.0	71.8
GK	305	21000	346	43.0	33.8
GK	346	34000	346	68.1 [f]	53.6 [f]
GK	346	69000	346	140.8 [g]	100.3 [g]
GK	406	14000	425	66.1	59.8
GK	406	21000	425	79.6	59.8
GK	425	34000	425	108.6	75.4

[a] Add 31.2 L to closing volume if secondary chamber is in use.

[b] Add 62.8 L to closing volume if secondary chamber is in use.

[c] Add 75.7 L to closing volume if secondary chamber is in use.

[d] Add 111.7 L to closing volume if secondary chamber is in use.

[e] Compact GK.

[f] With 216.9 mm piston stroke. Older model uses 247.7 mm piston stroke and 137.7 L to close, 93.3 L to open.

[g] With 266.7 mm piston stroke. Older model uses 247.7 mm piston stroke and 137.7 L to close, 93.3 L to open.

NL Shaffer - Annular Preventers, Diverters, and Strippers

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
SPHERICAL	103	69000	103	9.0	7.3
SPHERICAL	152	21000	179	17.3	12.2
SPHERICAL	152	34000	179	17.3	12.2
SPHERICAL	179	69000	179	64.8	52.8
SPHERICAL	203	21000	229	27.4	19.0
SPHERICAL	203	34000	229	41.4	33.1
SPHERICAL	254	21000	279	41.6	25.7
SPHERICAL	254	34000	279	70.7	55.2
SPHERICAL	279	69000	279	115.8	93.4
SPHERICAL	305	21000	346	89.0	55.5
SPHERICAL	346	34000	346	89.3	65.9
SPHERICAL	346	69000	346	194.0	161.6
SPHERICAL	425	34000	425	125.9	96.9
SPHERICAL	476	34000	476	182.3	142.4
SPHERICAL	508	14000	540	123.4	64.0
SPHERICAL	540	34000	540	232.3	180.8

Regan Forge & Engineering Co. - Annular Preventers, Diverters, and Strippers

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
K	76	21000	76	0.8	N/A
K	102	21000	102	3.0	N/A
K	178	21000	179	6.1	N/A
K	219	21000	200	12.9	N/A
K	245	21000	225	21.6	N/A
K	273	21000	254	28.8	N/A
K	299	21000	276	30.7	N/A
K	299	21000	283	39.0	N/A
K	340	21000	314	57.9	N/A
K	349	21000	349	75.3	N/A
K	406	21000	N/A	85.2	N/A
K	473	21000	N/A	111.7	N/A
KFD	406	2070	203	6.6	N/A
KFD	473	2070	203	9.5	N/A
KFD	508	2070	203	9.5	N/A
KFD	559	2070	203	11.4	N/A
KFD	610	2070	203	11.4	N/A
KFL	346	21000	346	73.8	N/A
KFL	346	34000	346	83.3	N/A
KFL	346	69000	346	92.7	N/A
KFL	426	21000	426	97.5	N/A
KFL	426	34000	426	109.8	N/A
KFL	426	69000	426	119.2	N/A
KFL	508	14000	527	107.9	N/A
KFL	508	21000	527	121.1	N/A
KFL	508	34000	527	132.5	N/A
KFL	762	6900	673	194.9	N/A
KFL	762	14000	673	212.0	N/A
KFL	762	6900	711	179.8	N/A
KFL	762	14000	711	196.8	N/A
TORUS	152	21000	179	16.3	N/A
TORUS	203	21000	229	30.7	N/A
TORUS	203	42000	229	30.7	N/A

Tesco - Annular Preventers, Diverters, and Strippers

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
DUAL	179	34000	179	12.9[a]	18.2[a]

[a] Each element.

Townsend International (Weatherford) - Annular Preventers, Diverters, and Strippers

Model or Type	BOP size (mm)	Working pressure (kPa)	Vertical bore (mm)	Litres to close	Litres to open
TYPE '84	179	21000	179	10.8	8.5
TYPE '84	179	34000	179	10.8	8.5
TYPE '84	229	21000	229	16.4	12.9
TYPE '84	229	34000	229	16.4	12.9
TYPE '84	279	21000	279	23.3	17.4

Cameron - Hydraulically Operated Valves

Model or Type	LINE SIZE (mm)	Working pressure (kPa)	Bore size (mm)	Litres to close	Litres to open
HCR	102	21000	102	2.3	2.0
HCR	102	34000	102	2.3	2.0
HCR	152	21000	178	8.5	7.4
HCR	152	34000	178	8.5	7.4
F	51	6600/21000	46	0.4	0.4
F	51	34000/103400	46	0.6	0.6
F	51	6600/21000	52	0.4	0.4
F	51	34000/103400	52	0.6	0.6
F	64	6600/69000	65	0.8	0.8
F	64	103400	65	1.5	1.5
F	76	6600/14000	79	0.6	0.6
F	76	21000/34000	79	0.9	0.9
F	76	69000	79	1.0	1.0
F	76	103400	79	1.9	1.9
F	102	14000/34000	105	1.1	1.1
F	102	69000	105	2.2	2.2
F	152	14000/34000	156	3.2	3.2
DV	102	21000	102	3.0	4.2
DV	102	34000	102	3.0	4.2
DV	152	21000	178	7.9	13.6
DV	203	21000	229	9.1	21.2
DV	254	21000	279	21.6	43.2
DV	254	34000	279	21.6	43.2
DV	305	21000	346	44.7	85.9

NL Shaffer - Hydraulically Operated Valves

Model or Type	LINE SIZE (mm)	Working pressure (kPa)	Bore size (mm)	Litres to close	Litres to open
FLO-SEAL	51	21000	52	0.8	0.8
FLO-SEAL	51 (reg)	34000	43	0.8	0.8
FLO-SEAL	51	34000	52	0.8	0.8
FLO-SEAL	52	69000	52	1.5	1.5
FLO-SEAL	52	103400	52	1.5	1.5
FLO-SEAL	64	14000	65	1.1	1.1
FLO-SEAL	64	21000	65	1.1	1.1
FLO-SEAL	64	34000	65	1.1	1.1
FLO-SEAL	76	14000	79	1.1	1.1
FLO-SEAL	76	21000	79	1.1	1.1
FLO-SEAL	76	34000	79	1.1	1.1
FLO-SEAL	78	69000	78	2.3	2.3
FLO-SEAL	102	21000	103	3.0	3.0
FLO-SEAL	102	34000	103	3.0	3.0
FLO-SEAL	103	69000	103	4.9	4.9
FLO-SEAL w RAM LOCK	51 (reg)	14000	43	1.1	1.1
FLO-SEAL w RAM LOCK	51	14000	52	1.1	1.1
FLO-SEAL w RAM LOCK	51 (reg)	21000	43	1.1	1.1
FLO-SEAL w RAM LOCK	51	21000	52	1.1	1.1
FLO-SEAL w RAM LOCK	51 (reg)	34000	43	1.1	1.1
FLO-SEAL w RAM LOCK	51	34000	52	1.1	1.1
FLO-SEAL w RAM LOCK	52	69000	52	1.5	1.5
FLO-SEAL w RAM LOCK	52	103400	52	1.5	1.5
FLO-SEAL w RAM LOCK	64	14000	65	1.1	1.1
FLO-SEAL w RAM LOCK	64	21000	65	1.1	1.1
FLO-SEAL w RAM LOCK	64	34000	65	1.1	1.1
FLO-SEAL w RAM LOCK	76	14000	79	1.5	1.5
FLO-SEAL w RAM LOCK	76	21000	79	1.5	1.5
FLO-SEAL w RAM LOCK	76	34000	79	1.5	1.5
FLO-SEAL w RAM LOCK	78	69000	78	2.3	2.3
FLO-SEAL w RAM LOCK	102	21000	103	3.0	3.0
FLO-SEAL w RAM LOCK	102	34000	103	3.0	3.0
FLO-SEAL w RAM LOCK	103	69000	103	3.0	3.0
DB	76	21000	79	1.1	1.1
DB	76	34000	79	1.1	1.1
DB	78	69000	78	2.3	2.3
DB	102	21000	103	3.0	3.0
DB	102	34000	103	3.0	3.0
DB	103	69000	103	4.9	4.9
DB	152	21000	179	7.6	7.6

Rockwell Manufacturing - Hydraulically Operated Valves					
Model or Type	LINE SIZE (mm)	Working pressure (kPa)	Bore size (mm)	Litres to close	Litres to open
AC VALVE w U-1 HYD	51	14000	N/A	0.5	0.4
	51	21000	N/A	0.5	0.4
	51	34000	N/A	0.5	0.4
	51	69000	N/A	0.8	1.8
	64	14000	N/A	1.0	0.9
	64	21000	N/A	1.0	0.9
	64	34000	N/A	1.0	0.9
	64	69000	N/A	1.7	1.6
	76	14000	N/A	1.1	0.9
	76	21000	N/A	1.9	1.7
	76	34000	N/A	1.9	1.7
	102	14000	N/A	2.6	2.3
	102	21000	N/A	2.6	2.3
	102	34000	N/A	3.9	3.7

Appendix 10 Well Control Data

Well Control Kill Sheet

Well Total Depth ______ m Casing Depth ______ m Date _______

PUMP DATA

Pump Bore Diameter_____mm x Stroke Length _____mm RSPP _______kPa

Pump Output ________m^3/stroke x SPM $_{Reduced}$ = _________ m^3/min

VOLUME AND DISPLACEMENT TIME

	Length	Capacity	Volume	Minutes	Strokes
Drill Pipe					
OH Annulus					
Casing Annulus					
Subtotals					
Mud totals					
TOTAL					

CALCULATIONS

MACP with Original Mud Density

Fracture Pressure = Depth of casing ______m x Leak-off gradient ______ kPa/m =________ kPa

Hydrostatic Pressure = Depth of casing ______m x Original Mud ______ kPa/m^3 x 0.00981 = ________ kPa

MACP = Fracture Pressure _____ kPa ÷ depth _______m ÷ 0.00981 = ________ kPa

Density Increase = SIDPP ______ kPa ÷ Depth ________ m ÷ 0.00981 =________ kg/m^3

Kill Mud = Density Increase ______ kg/m^3 + Original Density ______ kg/m^3 =________ kg/m^3

Barite Required = 4250 x Density Increase _________ kg/m^3 / 4250 - Kill Mud _______ kg/m^3 =________ kg/m^3

Total Barite = Barite Required _______ kg/m^3 x Volume _______m^3 =________ kg

Number of Sacks = Total Barite ______ kg ÷ 40 kg/sack =________ sacks

Mixing Rate = Number of Sacks _____sacks ÷ Minutes $_{(R)}$ _______ minutes =________ sacks/min

Initial Circulating Pressure = RSPP _____ kPa x Mud Kill _____kg/m^3 / Original Mud _____ kg/m^3 = _______ kPa

Final Circulating Pressure = RSPP _____kPa x Kill Mud_____kg/m^3 / Original Mud ______ kg/m^3 = ________ kPa

MAXIMUM ALLOWABLE CASING PRESSURE

Fracture Pressure = Depth of casing ______m x Leak-off gradient ______ kPa/m =________kPa

Hydrostatic Pressure = Depth of casing ______m x Original Mud ______kPa/m^3 x 0.00981 = ________kPa

Maximum **A**llowable **C**asing **P**ressure with Kill Mud **(MACP)** ______ kPa

M.R. Mixing Rate P.O. Pump Output

Well Control Formulas

1) Depth = True vertical depth (TVD)
2) Hydrostatic pressure (kPa) = Mud density (kg/ m^3) x Depth (m) x 0.00981
3) Hydrostatic pressure (kPa) = Gradient (kPa/m) x Depth (m)
4) Mud gradient (kPa/ m^3) = Mud density (kg/m) x 0.00981
5) Mud density (kg/ m^3) = Gradient (kPa/m) ÷ 0.00981
6) Formation pressure (kPa) =
   Hydrostatic pressure (kPa) + Shut-in drill pipe pressure (SIDPP) (kPa)
7) Kill mud density (kg/ m^3) = Formation pressure (kPa) ÷ Depth (m) ÷ 0.00981
8) Equivalent mud density or circulation density =
   Effective bottomhole pressure (kPa) ÷ Depth (m) ÷ 0.00981

Gas Expansion Calculations

Where: V = Volume (m^3)
P = Pressure (kPa)
V_1 = initial volume of gas entering the wellbore (pit gain)
P_1 = initial pressure acting on the gas when it entered the wellbore
V_2 = expanded volume of gas as it rises
P_2 = new pressure acting on the gas bubble as it rises
Atmospheric pressure = 100 kPa

1) $V_1 \times P_1 = V_2 \times P_2$

2) $$V_2 = \frac{V_1 \times P_1}{P_2}$$

or

$$V_2 = V_1 \times P_1 \div P_2$$

Well Killing Calculations

1) Density increase (kg/m^3) = SIDPP (kPa) ÷ Depth (m) ÷ 0.00981

2) Kill mud density (kg/m^3) = Density increase + Original density (kg/m^3)

3) $$\text{Barite required (kg/m}^3\text{)} = \frac{4250 \times \text{Density increase (kg/m}^3\text{)}}{4250 - \text{Kill mud density (kg/m}^3\text{)}}$$

4) Total barite required (kg) = Barite required (kg/m^3) x Total volume (m^3)

5) Number of sacks = Total barite required (kg) ÷ 40 kg/sack

6) Mixing rate (sacks/min.) = Number of sacks ÷ Reduced circulation time

7) Initial circulating pressure (kPa) = RSPP + SIDPP + Overkill

8) Final circulating pressure (kPa) = [(RSPP (kPa) x Kill mud density (kg/m^3)/Original mud density (kg/m^3)] + Overkill (kPa)

Leak-off Calculations

1) Formation leak-off pressure at shoe (kPa) = Hydrostatic pressure at shoe (kPa) + Applied surface pressure

2) Leak-off gradient (kPa/m) = Formation leak-off pressure at shoe (kPa) ÷ Casing depth (m)

3) Equivalent mud density (kg/m^3) = Leak-off gradient (kPa/m) ÷ 0.00981

4) Maximum allowable casing pressure (kPa) = Formation leak-off pressure at shoe (kPa) – New hydrostatic pressure at shoe (kPa)

Stripping/Snubbing Calculations

1) 1000 mm = 1 m

2) Area (m^2) = 0.785 x Tool joint diameter x Tool joint diameter
where: Tool joint diameter is in metres
0.785 = constant

3) Wellbore force (daN) = Pressure x Area x 100
where: Pressure = Shut-in casing pressure
Area = m^2
100 = constant

4) Total force acting on a string (daN) =
Friction force in the BOP (daN) + Wellbore force

5) Length of pipe to snub (m) = Total force (daN) ÷ Mass (m) ÷ 0.981

Table 1 . Drill pipe capacities and displacements (SI)

Size O.D. (mm)	Mass (w/couplings) kg/m	Inside diameter (mm)	Displacement(m^3/m)	Capacity (m^3/m)
60.33	7.22	50.67	0.00092	0.00200
	9.90	46.10	0.00126	0.00170
73.03	9.60	62.71	0.00122	0.00310
	10.19	62.00	0100130	0.00300
	12.43	59.00	0.00159	0.00270
	15.48	54.64	0.00197	0.00230
	15.48	54.64	0.00198	0.00234
88.90	12.65	77.80	0.00161	0.00480
	14.14	76.00	0.00180	0.00450
	16.67	73.66	0.00213	0.00430
	19.79	70.21	0.00254	0.00390
	23.07	66.09	0.00294	0.00340
	23.09	66.09	0.00318	0.00343
101.60	17.63	88.29	0.00225	0.00610
	20.83	84.84	0.00266	0.00570
	20.84	84.48	0.00271	0.00570
	23.36	82.30	0.00298	0.00530
114.30	18.97	101.60	0.00242	0.00810
	20.46	100.53	0.00261	0.00790
	24.70	97.18	0.00315	0.00740
	24.71	97.18	0.00331	0.00740
	29.76	92.46	0.00380	0.00670
	29.77	92.45	0.00420	0.00670
127.00	24.18	111.96	0.00309	0.00980
	29.06	108.61	0.00400	0.00930
	38.14	101.60	0.00510	0.00800
139.70	32.59	121.36	0.00416	0.01160
	36.76	118.62	0.00469	0.01110
141.30	29.28	126.37	0.00361	0.01250
	33.04	123.42	0.00421	0.01200
	37.58	120.22	0.00479	0.01140
168.28	33.04	154.05	0.00421	0.01860
	37.50	151.49	0.00478	0.01800
	47.47	146.33	0.00606	0.01680
193.68	43.53	177.01	0.00555	0.02460

Table 2. Drill collar displacements and capacity

O.D. (mm)	I.D. (mm)	Mass (kg/m)	Capacity (m^3/m)	Displacement (mm^3/m)
166.1	38.1	107.0	0.0012	0.0203
166.1	44.5	104.8	0.0016	0.0199
166.1	50.8	102.3	0.0020	0.0194
166.1	57.2	99.5	0.0026	0.0189
166.1	63.5	96.3	0.0032	0.0183
166.1	69.9	32.8	0.0038	0.0176
166.1	76.2	89.0	0.0045	0.0169
166.1	82.6	84.8	0.0054	0.0161
166.1	88.9	80.3	0.0062	0.0152
171.5	38.1	116	0.0012	0.0220
171.5	44.5	113.8	0.0016	0.0216
171.5	50.8	111.3	0.0020	0.0211
171.5	57.2	108.5	0.0026	0.0206
171.5	63.5	105.3	0.0032	0.0200
171.5	69.9	101.8	0.0038	0.0193
171.5	76.2	98.0	0.0045	0.0186
171.5	82.6	93.8	0.0054	0.0178
171.5	88.9	89.3	0.0062	0.0170
177.8	38.1	186.00	0.0012	0.0237
177.8	44.5	182.73	0.0016	0.0233
177.8	50.8	179.01	0.0020	0.0229
177.8	57.2	174.84	0.0026	0.0223
177.8	63.5	170.08	0.0032	0.0217
177.8	69.9	164.87	0.0038	0.0210
177.8	76.2	159.22	0.0045	0.0203
177.8	82.6	152.97	0.0054	0.0195
177.8	88.9	146.27	0.0062	0.0187
177.8	95.3	138.99	0.0072	0.0177
177.8	101.6	121.39	0.0081	0.0167

Table 3. Hole capacity (SI)

Diameter of hole (mm)	m^3/linear metre	Linear metres/m^3
152.400	0.0182	54.80
155.575	0.0190	52.59
158.750	0.0198	50.50
161.925	0.0206	48.54
165.100	0.0214	46.69
168.275	0.0222	44.95
171.450	0.0231	43.95
174.625	0.0240	41.74
177.800	0.0248	40.26
180.975	0.0257	38.86
184.150	0.0266	37.53
187.325	0.0276	36.27
190.500	0.0285	35.07
193.675	0.0295	33.93
196.850	0.0304	32.85
200.025	0.0314	32.81
203.200	0.0324	30.82
206.375	0.0335	29.88
209.550	0.0345	28.98
212.725	0.0356	28.13
215.900	0.0366	27.30
219.075	0.0377	26.52
222.250	0.0388	25.77
225.425	0.0399	25.05
228.600	0.0411	24.36
231.775	0.0422	23.69
234.950	0.0434	23.06
368.125	0.0446	22.45
241.300	0.0457	21.86
244.475	0.0470	21.29
247.650	0.0482	20.75
250.825	0.0494	20.23

Table 4. Annular volume drill pipe and open hole (m^3/m)

Hole size (mm)	73	88.9	101.6	114.3	127
120.65	0.0073				
149.23	0.0133	0.0113			
152.40	0.0140	0.0121			
155.58	0.0148	0.0128			
158.75	0.0156	0.0136			
165.10	0.0172	0.0152			
168.28	0.0180	0.0160			
171.45	0.0189	0.0169	0.0149	0.0128	
187.33	0.0234	0.0213	0.0194	0.0173	
193.68	0.0253	0.0233	0.0213	0.0192	
200.02	0.0272	0.0255	0.0233	0.0212	0.0188
121.73	0.0314	0.0293	0.0274	0.0253	0.0229
215.90	0.0324	0.0304	0.0284	0.0263	0.0239
219.08	0.0355	0.0315	0.0295	0.0274	0.0250
222.25	0.0346	0.0326	0.0306	0.0285	0.0261
228.60	0.0369	0.0346	0.0329	0.0308	0.0284
241.30	0.0415	0.0395	0.0376	0.0355	0.0331
244.48	0.0428	0.0407	0.0388	0.0367	0.0343
250.83	0.0452	0.0432	0.0413	0.0392	0.0367
269.88	0.0530	0.0510	0.0491	0.0470	0.0446
279.40	0.0571	0.0551	0.0532	0.0511	0.0487
304.80	0.0688	0.0668	0.0648	0.0627	0.0603
311.15	0.0718	0.0698	0.0679	0.0658	0.0634
342.90	0.0882	0.0861	0.0842	0.0821	0.0797
349.25	0.0916	0.0896	0.0876	0.0855	0.0831
374.65	0.1060	0.1040	0.1021	0.1000	0.0976
381.00	0.1098	0.4078	0.1059	0.1038	0.1014
406.4	0.1255	0.1235	0.1216	0.1195	0.1171

Table 5. Annular volume drill pipe and casing (m^3/m) (SI)

Casing O.D. (mm)	Mass (kg/m)	60.3	73	88.9	101.6	114.3	127
114.3	14.14	0.0056	0.0043				
	15.63	0.0055	0.0041				
	17.26	0.0053	0.0039				
	20.09	0.0049	0.0036				
	22.47	0.0046	0.0032				
127	17.11	0.0077	0.0064				
	19.35	0.0074	0.0060				
	22.32	0.0070	0.0057				
	26.79	0.0064	0.0051				
	31.21	0.0060	0.0047				
	34.53	0.0054	0.0041				
	20.83	0.0099	0.0085	0.0065	0.0046		
	23.07	0.0096	0.0082	0.0062	0.0043		
	25.30	0.0093	0.0079	0.0059	0.0040		
	29.76	0.0087	0.0074	0.0054	0.0035		
	34.23	0.0082	0.0069	0.0048	0.0029		
	38.69	0.0076	0.0063	0.0043	0.0024		
168.3	29.76	0.0157	0.0144	0.0123	0.0104		
	35.72	0.0159	0.0136	0.0116	0.0097		
	41.67	0.0141	0.0128	0.0108	0.0089		
	47.62	0.0135	0.0121	0.0101	0.0082		
177.8	25.30	0.0188	0.0175	0.0155	0.0136		
	29.76	0.0183	0.0169	0.0149	0.0130		
	34.23	0.0177	0.1064	0.0143	0.0124		
	38.69	0.0171	0.0158	0.0138	0.0119		
	43.16	0.0165	0.0152	0.0132	0.0113		
	47.62	0.0160	0.0146	0.0126	0.0107		
	52.09	0.0154	0.0141	0.0121	0.0102		
	56.55	0.0149	0.0136	0.0116	0.0097		
193.7	35.72	0.0222	0.0208	0.0188	0.0169	0.0148	
	39.29	0.0218	0.0204	0.0184	0.0165	0.0144	
	44.20	0.0211	0.0198	0.0177	0.0158	0.0137	
	50.15	0.0203	0.0190	0.0170	0.0151	0.0129	
	58.04	0.0194	0.0181	0.0160		0.0120	
219.1	35.72	0.0304	0.0290	0.0270	0.0251	0.0230	
	41.67	0.0297	0.0284	0.0264	0.0245	0.0223	
	47.62	0.0289	0.0276	0.0256	0.0267	0.0215	
	53.57	0.0282	0.0268	0.0248	0.0229	0.0208	
	59.53	0.0274	0.0261	0.0240	0.0221	0.0200	
	65.48	0.0266	0.0253	0.0233	0.0214	0.0192	
	72.92	0.0257	0.0244	0.0244	0.0205	0.0183	

(continued)

Table 5. Annular volume drill pipe and casing (m^3/m) (SI) (concluded)

Casing O.D. (mm)	Mass (kg/m)	60.3	73	88.9	101.6	114.3	127
244.5	48.07	0.0382	0.0369	0.0349	0.0330	0.0308	0.0284
	53.57	0.0375	0.0362	0.0341	0.0322	0.0300	0.0277
	59.53	0.0367	0.0354	0.0334	0.0315	0.0293	0.0269
	64.74	0.0360	0.0347	0.0326	0.0307	0.0286	0.0262
	69.64	0.0353	0.0340	0.0320	0.0301	0.0279	0.0255
	79.62	0.0341	0.0327	0.0307	0.0288	0.0267	0.0243
	86.91	0.0332	0.0319	0.0299	0.0280	0.0256	0.0234
	90.93	0.0327	0.0314	0.0293	0.0274	0.0253	0.0229
	106.85	0.0306	0.0293	0.0273	0.0254	0.0232	0.0208
273.1	48.74	0.0498	0.0485	0.0464	0.0445	0.0424	0.0400
	60.27	0.0483	0.0470	0.0450	0.0431	0.0409	0.0385
	67.71	0.0473	0.0460	0.0440	0.0421	0.0399	0.0375
	75.90	0.0463	0.0450	0.0430	0.0411	0.0389	0.0365
	82.59	0.0454	0.0441	0.0421	0.0402	0.0380	0.0356
	90.33	0.0444	0.0431	0.0411	0.0392	0.0370	0.0346
	97.77	0.0435	0.0421	0.0401	0.0382	0.0360	0.0336
298.5	62.50	0.0594	0.0589	0.0560	0.0541	0.0520	0.0496
	69.94	0.0585	0.0571	0.0551	0.0532	0.0511	0.0487
	80.36	0.0571	0.0558	0.0537	0.0518	0.0497	0.0473
	89.29	0.0559	0.0546	0.0526	0.0507	0.0485	0.0461
339.7	71.43	0.0791	0.0777	0.0757	0.0738	0.0717	0.0693
	81.10	0.0778	0.0765	0.0744	0.0725	0.0704	0.0380
	90.78	0.0765	0.0752	0.0731	0.0713	0.0691	0.0667
	101.20	0.0752	0.0739	0.0719	0.0700	0.0679	0.0654
	107.15	0.0747	0.0734	0.0714	0.0695	0.0673	0.0649
406.4	96.73	0.1150	0.1121	0.1116	0.1097	0.1076	0.1052
	111.61	0.1130	0.1117	0.1097	0.1078	0.1056	0.1031
	125.00	0.1113	0.1100	0.1080	0.1060	0.1039	0.1015
473.1	130.21	0.1568	0.1555	0.1535	0.1516	0.1495	0.1470
508	139.89				0.1772	0.1451	0.1727
	158.49				0.1748	0.1727	0.1703
	197.93				0.1696	0.1675	0.1651

Table 6. Dimensions and burst pressures of casing (KPa) (SI)

Casing O.D. (mm)	Mass (kg/m)	H-40	J-55	K-55	C-75	N-80	C-95	P-110
193.7	35.72	28 545						
	39.29		28 545	28 545	38 888	41 508	49 299	
	44.20				44 473	47 507	56 401	65 296
	50.15				51 023	54 471	64 675	74 880
	58.04				59 366	63 296	75 155	87 015
219.1	35.72		20 340	20 340				
	41.67	17 030						
	47.62	19 720	27 097	27 097				
	53.57		30 752	30 752	41 990	44 749	53 160	
	59.53				47 230	50 333	59 790	69 226
	65.48				52 470	56 056	66 468	76 948
	72.92				58 470	62 330	74 052	85 705
244.5	48.07	15 652						
	53.57	17 651	24 270	24 270				
	59.53		27 235	27 235	37 164	39 646	47 024	
	64.74				40 887	43 645	51 781	60 055
	69.94				44 403	47 396	56 194	65 088
	79.62				51 230	54 677	64 882	75 156
273.1	48.74	12 549						
	60.27	15 720	21 581	21 581				
	67.71		24 684	24 684				
	75.90		27 787	27 787	37 853	40 404	47 989	55 574
	82.59				41 645	44 472	52 816	61 089
	90.33							67 295
	97.77							73 121
298.5	62.50	13 652						
	69.94		21 167	21 167				
	80.36		24 546	24 546				
	89.29		27 649	27 649	37 646	40 198	47 713	
339.7	71.43	11 928						
	81.10		18 823	18 823				
	90.78		21 305	21 305				
	101.20		23 787	23 787				
	107.15					37 095	44 059	
406.4	96.73	11 308						
	111.61		18 134	18 134				
	125.01		20 547	20 547				
473.1	130.21	11 239	15 514	15 514				

Table 7. Double-acting duplex mud pump capacities per cycle (SI) (m^3/revolution; 90% volumetric efficiency; rod deducted)

Liner size (mm)	Stroke length (mm)					
	304.8	355.6	381	406.4	457.2	508
101.6	0.00787	0.00917	—	—	—	—
108	0.00894	0.01041	—	—	—	—
114.3	0.01013	0.01181	0.01229	0.01380	0.01424	0.01584
120.7	0.01143	0.01332	0.01391	0.01485	0.01620	0.01801
127	0.01278	0.01491	0.01561	0.01644	0.01823	0.02027
133.4	0.01421	0.01657	0.01738	0.01854	0.02036	0.02264
139.77	0.01571	0.01830	0.01927	0.02054	0.02262	0.02514
146.1	0.01727	0.02016	0.02126	0.02262	0.02469	0.02775
125.4	0.01891	0.02207	0.02323	0.02480	0.02742	0.03046
158.8	0.02061	0.02405	0.02542	0.02707	0.02997	0.03310
165.4	0.02239	0.02607	0.02760	0.02944	0.03262	0.03625
171.5	0.02422	0.02825	0.02990	0.03189	0.03539	0.03934
177.8	0.02614	0.03049	0.03228	0.03443	0.03925	0.04252
184.2	0.02811	0.03279	0.03477	0.03707	0.04122	0.04582
190.5	—	—	0.03733	0.03981	0.04431	0.04923
196.9	—	—	0.39970	0.04264	0.04749	0.05277

Table 8. Double-acting single mud pump capacities per cycle (SI) (m^3/revolution; 100% volumetric efficiency)

	Stroke length (mm)						
Liner size (mm)	**177.8**	**190.5**	**203.2**	**228.6**	**254**	**279.4**	**305**
76.2	0.00243	0.00261	0.00278	0.00313	0.00332	0.00382	0.00417
82.6	0.00285	0.00305	0.00326	0.00367	0.00409	0.00450	0.00488
88.9	0.00331	0.00355	0.00378	0.00424	0.00474	0.00518	0.00568
95.2	0.00378	0.00409	0.00434	0.00488	0.00541	0.00598	0.00649
101.6	0.00431	0.00461	0.00474	0.00566	0.00617	0.00682	0.00742
108	0.00488	0.00521	0.00556	0.00628	0.00696	0.00768	0.00836
114.3	0.00548	0.00587	0.00623	0.00704	0.00784	0.00858	0.00938
120.7	0.00609	0.00653	0.00696	0.00784	0.00870	0.00957	0.01044
127	0.00677	0.00723	0.00773	0.00871	0.00965	0.01064	0.01159
133.4	0.00745	0.00798	0.00851	0.00957	0.01064	0.01170	0.01275
139.7	0.00817	0.00874	0.00953	0.01051	0.01170	0.01283	0.01400
146	0.00993	0.00957	0.01022	0.01146	0.01275	0.01404	0.01533
152.4	0.00971	0.01041	0.01113	0.01250	0.01389	0.01528	0.01669
158.8	0.01056	0.01132	0.01207	0.01359	0.01507	0.01658	0.01809
156.1	0.01143	0.01223	0.01305	0.01469	0.01631	0.01795	0.01960
141.5	0.01230	0.01320	0.01409	0.01582	0.01760	0.01935	0.02111
177.8	0.01324	0.01420	0.01513	0.01703	0.01892	0.02083	0.02273

Appendix 11 Crew Shut-in Procedures

SHUT-IN PROCEDURES – WHILE DRILLING

Crew Member	Driller	Derrick Hand	Motor Hand	Floor Hand #1	Floor Hand #2
Position	(1) Floor (2) Choke manifold	(1) Floor (2) Mud Tanks	(1) Floor (2) Choke Manifold	(1) Floor (2) Choke Manifold	(1) Floor (2) Messenger
Duties: FLOW CHECK SHUT-IN	CALL ALERT	Go to Floor	Go to Floor	Go to Floor	Go to Floor
	RAISE KELLY	Go to Mud Tanks	Go to Choke Manifold	Assist Motor Hand	Assist Driller
	STOP PUMP	MONITOR TRIP TANK			
	OPEN HYDRAULIC VALVE				
	CLOSE ANNULAR PREVENTER Go to choke manifold or to hydraulic choke control panel		SLOWLY CLOSE CHOKE (Do not exceed max. allowable SICP)		
	LET PRESSURES STABILIZE (5-15 min.) READ & RECORD SIDPP READ & RECORD SICP RECORD TRIP TANK GAIN	REPORT INCREASE IN TRIP TANK VOLUME			
	PREPARE TO KILL WELL				At direction of Driller, NOTIFY RIG MANAGER & LICENSEE'S REPRESENTATIVE

SHUT-IN PROCEDURES – WHILE TRIPPING

Crew Member	Driller	Derrick Hand	Motor Hand	Floor Hand #1	Floor Hand #2
Position	(1) Floor (2) Choke manifold	(1) Floor (2) Mud Tanks	(1) Floor (2) Choke Manifold	(1) Floor (2) Choke Manifold	(1) Floor (2) Messenger
Duties: FLOW CHECK SHUT-IN	CALL ALERT	Remain in derrick until called down	Go to Floor	Go to Floor	Go to Floor
	POSITION UPPER TOOL JOINT ABOVE TABLE				
		Go to Mud Tanks	SET SLIPS AND REMOVE ELEVATORS	SET SLIPS AND REMOVE ELEVATORS	SET SLIPS AND REMOVE ELEVATORS
		MONITOR TRIP TANK	Go to Choke Manifold	INSTALL STABBING VALVE IN OPEN POSITION; CLOSE	INSTALL STABBING VALVE IN OPEN POSITION; CLOSE
	OPEN HYDRAULIC VALVE				
	CLOSE ANNULAR PREVENTER		SLOWLY CLOSE CHOKE (Do not exceed max. allowable SICP)	Assist Driller	Assist Driller
	INSTALL KELLY OPEN STABBING VALVE Go to Choke Manifold or to hydraulic choke control panel			INSTALL KELLY	INSTALL KELLY
	LET PRESSURES STABILIZE (5-15 min.) READ & RECORD SIDPP READ & RECORD SICP RECORD TRIP TANK GAIN	REPORT INCREASE IN TRIP TANK VOLUME		Assist Motor Hand	
	PREPARE TO KILL WELL OR STRIP IN				At direction of Driller, NOTIFY RIG MANAGER & LICENSEE'S REPRESENTATIVE

SHUT-IN PROCEDURES – WHILE OUT OF THE HOLE

Crew Member	Driller	Derrick Hand	Motor Hand	Floor Hand #1	Floor Hand #2
Position	(1) Floor (2) Choke manifold	(1) Floor (2) Mud Tanks	(1) Floor (2) Choke Manifold	(1) Floor (2) Choke Manifold	(1) Floor (2) Messenger
Duties: FLOW CHECK SHUT-IN	CALL ALERT	Go to Floor	Go to Floor	Go to Floor	Go to Floor
	OPEN HYDRAULIC VALVE CLOSE BLIND RAMS	Assist Driller Go to Mud tanks	Go to Choke Manifold	Assist Motor Hand	Assist Driller
	Go to Choke Manifold or to hydraulic choke control panel	MONITOR TRIP TANK	SLOWLY CLOSE CHOKE (Do not exceed max. allowable SICP)		
	LET PRESSURE STABILIZE (5-15 min.) READ & RECORD SICP RECORD TRIP TANK AGAIN	REPORT INCREASE IN TRIP TANK VOLUME			
	PREPARE TO STRIP IN, SNUB, OR TOP KILL WELL				At direction of Driller, NOTIFY RIG MANAGER & LICENSEE'S REPRESENTATIVE

Appendix 12 Crew Training Assessment Form

Licensee

Unique Identifier

LE	LSD	SEC	TWP	RG	W	M	EV

Date

M	D	Y

Licensee Representative

Contractor Representative

Contractor

Rig #

EUB Inspector

Operations at the time of the BOP drill Drilling ☐ Tripping ☐ Out of hole ☐

FLOW CHECK PROCEDURES

DRILLING

	Yes	No
Alert called		
Rotary stopped		
Kelly hoisted		
Tool joint (TJ) positioned		
Pump shut off		
Flow diverted to trip tank (TT)		
TT zeroed		
Monitored TT for flow		

TRIPPING

	Yes	No
Alert called		
TJ positioned		
Slips set		
Elevators removed		
Stabbing valve installed		
Hole filled		
Pump shut off		
Flow diverted to TT		
TT zeroed		
Monitored TT for flow		

OUT OF HOLE

	Yes	No
Alert called		
Hole filled		
Pump shut off		
Flow diverted to TT		
TT zeroed		
Monitored TT for flow		

SHUT-IN PROCEDURES

DRILLING

	Yes	No
Alert called		
Rotary stopped		
Kelly hoisted		
(TJ) positioned		
Pump shut off		
HCR opened		
Annular closed		
Choke slowly closed		
Pressures stabilized		
SICP & SIDPP recorded		
Gains recorded		
Supervisors notified		
Prepared to kill well		

TRIPPING

	Yes	No
Alert called		
TJ positioned		
Slips set		
Elevators removed		
Stabbing valve installed		
HCR opened		
Annular closed		
Choke slowly closed		
Kelly installed		
Stabbing valve opened		
Pressures stabilized		
SICP & SIDPP recorded		
Supervisors notified		
Prepared to trip in or kill		

OUT OF HOLE

	Yes	No
Alert called		
Hole filled		
Pump shut off		
HCR opened		
Blind rams closed		
Choke slowly closed		
Pressures stabilized		
SICP recorded		
Supervisors notified		
Prepared to trip in or kill		

(continued)

Crew Training Assessment Form (page 2)

RESPONSE TIMES

		Recommended	Actual
1)	Time to respond to alert:	1 minute	______
2)	Procedures for flow checks completed; well is ready for flow check:	3 minutes	______
3)	Well is shut in and ready to record pressures:	5 minutes	______

CREW ASSESSMENT (YES/NO)

1) Did all crew members respond to alert? ______________________________

2) Did all crew members know their positions and responsibilities? ____________________

3) Was flow check completed in the proper manner? ____________________________.

4) Was well shut-in completed in the proper manner? ____________________________

5) Was maximum allowable casing pressure (MACP) understood by licensee and contractor representatives, driller, and choke operator? ______________________________________

6) Did crew know how to obtain SIDPP, SICP, and tank gain? ____________________________

7) Did driller know the reduced pump speed and reduced pump pressure? ____________________

8) Does driller understand well control methods/procedures? ____________________________

COMMENTS:

Appendix 13 Fluid Level Drop from Surface

When tripping pipe from a well, the well must be filled with drilling fluid at sufficiently frequent intervals so that the fluid level in the wellbore does not drop below a depth of 30 m from surface.

The maximum length of drill pipe that can be pulled while tripping before the level drops 30 m from surface when the pipe is removed from the well depends on

- the dimensions of the drill pipe,
- the internal diameter of the casing, and
- whether the drill pipe is pulled dry or wet.

Calculation—Pulling Dry Pipe

The calculation below is based on the assumption that the fluid level in the drill pipe remains the same height as the fluid level in the annulus. The volume of steel removed (drill pipe) must equal the volume of mud required to replace the resulting drop in fluid level.

Therefore, the maximum length of drill pipe that can be pulled before the fluid level drops 30 m from surface can be calculated with the following method:

1) Determine annular capacity (m^3/m), drill pipe capacity (m^3/m), and drill pipe displacement (m^3/m).

   Maximum annular fluid volume drop (m^3) = 30 m x [annular capacity (m^3/m) + drill pipe capacity (m^3/m)]

2) The maximum allowable drill pipe length that can be pulled (m) =

$$\frac{\text{maximum annular fluid volume drop } (m^3)}{\text{drill pipe displacement } (m^3/m)}$$

Example 1

Tubular Data:

Casing size	244.5 mm	Drill pipe size	114.30 mm
Grade	J55/K55	Mass	29.77 kg/m
Mass	53.57 kg/m		

Annular volume = 0.030 m^3/m
Drill pipe capacity = 0.0067 m^3/m
Drill pipe displacement = 0.0042 m^3/m

1) A 30 m drop in the annulus is also a 30 m drop inside the drill pipe:

   Volume of a 30 m drop = 30 m x [0.030 + 0.0067] m^3/m = 1.10 m^3

2) Length of dry drill pipe to be pulled to drop fluid 30 m in annulus:

$$\frac{\text{Volume of 30 m drop}}{\text{Drill pipe displacement}} = \frac{1.10\ \text{m}^3}{0.0042\ \text{m}^3/\text{m}} = 262\ \text{m of pipe}$$

Example 2

Tubular Data:

Casing size	177.8 mm	Drill pipe size	101.6 mm
Grade	H40	Mass	20.83 kg/m
Mass	29.76 kg/m		

Annular volume = 0.0130 m^3/m
Drill pipe capacity = 0.0057 m^3/m
Drill pipe displacement = 0.0027 m^3/m

1) A 30 m drop in the annulus is also a 30 m drop inside the drill pipe:
   30 m x [0.0130 + 0.0057] m^3/m = 0.561 m^3

2) Length of dry drill pipe to be pulled to drop fluid 30 m in annulus:

$$\frac{\text{Volume of 30 m drop}}{\text{Drill pipe displacement}} = \frac{0.561\ \text{m}^3}{0.0027\ \text{m}^3/\text{m}} = 208\ \text{m of pipe}$$

Calculation—Pulling Wet Pipe

The calculation below is based on the assumption that the volume of fluid in the drill pipe remains in the drill pipe as the pipe is being pulled. When the stand is unscrewed, the fluid level in the drill pipe in the well remains full. Therefore, the volume of steel plus the volume of fluid in the drill pipe removed must equal the volume of mud in the annulus (between the casing and drill pipe) required to replace the resulting drop in fluid level.

Therefore, the maximum length of wet drill pipe that can be pulled before the fluid level drops to 30 m can be calculated with the following method:

1) Determine the annular capacity (m^3/m), drill pipe capacity (m^3/m), and drill pipe displacement (m^3/m).

2) Maximum annular fluid volume drop (m^3) = 30 m x annular capacity (m^3/m).

3) The maximum allowable drill pipe length that can be pulled (m)

$$= \frac{\text{maximum annular fluid volume (m}^3\text{)}}{\text{drill pipe displacement (m}^3\text{/m)} + \text{drill pipe capacity (m}^3\text{/m)}}$$

Example 1

Tubular Data:

Casing size	244.5 mm	Drill pipe size	114.30 mm
Grade	J55/K55	Mass	29.76 kg/m
Mass	53.57 kg/m		

Annular volume = 0.030 m^3/m
Drill pipe capacity = 0.0067 m^3/m
Drill pipe displacement = 0.0042 m^3/m

1) Volume of 30 m drop in annulus (but not in drill pipe) = 30 m x 0.030 m^3/m = 0.9 m^3

2) Length of wet pipe pulled to drop fluid 30 m in annulus

$$= \frac{\text{Volume of 30 m drop}}{\text{drill pipe capacity + drill pipe displacement}}$$

$$= \frac{0.9\ m^3}{0.0067 m^3/m + 0.0042\ m^3/m} = 83 \text{ m of pipe}$$

Example 2

Tubular Data:

Casing size	177.8 mm	Drill pipe size	101.6 mm
Grade	H40	Mass	20.83 kg/m
Mass	29.76 kg/m		

Annular volume = 0.0130 m^3/m
Drill pipe capacity = 0.0057 m^3/m
Drill pipe displacement = 0.0027 m^3/m

1) Volume of 30 m drop in annulus (but not in drill pipe) = 30 m x 0.39 m^3/m = 0.9 m^3

2) Length of wet drill pipe pulled to drop fluid 30 m in annulus

$$= \frac{\text{Volume of 30 m drop}}{\text{drill pipe capacity + drill pipe displacement}}$$

$$= \frac{0.39\ m^3}{0.0057 m^3/m + 0.0027\ m^3/m} = 47 \text{ m of pipe}$$

Appendix 14 Electrical Inspections of Drilling Rigs

The following document describes and formalizes the roles and expectations of the EUB and Alberta Municipal Affairs – SSB regarding the electrical conditions at rigs. It is important to note that all jurisdiction of electrical systems at rigs remains with Alberta Municipal Affairs – SSB.

EUB Roles and Expectations

EUB inspectors conduct inspections of drilling rigs to ensure compliance with EUB requirements. They are not inspecting the electrical systems on those rigs. However, if during an EUB inspection an obvious problem with the electrical system is noticed (frayed and/or tattered cords, light protectors missing, evidence of shorting and/or sparking), the inspector should make note in the comments section of the Drilling and Servicing Inspection Report and forward a copy to Alberta Municipal Affairs – SSB at the address noted at the end of this section.

It is the responsibility of the operator and contractor representatives to ensure electrical compliance. EUB staff will not follow up on these reminders. Repeat electrical problems would fall within the jurisdiction of Alberta Municipal Affairs – SSB.

Background

Alberta Municipal Affairs – SSB inspection staff do not normally inspect electrical systems on drilling rigs once the rigs are in service. They are concerned that all rigs are prone to electrical system deterioration due to their constant movement. Although EUB staff do not have formal training in electrical systems, it is felt that EUB staff could assist the SSB by reminding personnel at rigs with questionable electrical systems of their responsibilities and informing Alberta Municipal Affairs – SSB. The EUB has no jurisdiction to enforce any requests for remedial work on electrical systems.

Goals of This Agreement

i) To help ensure electrical systems on rigs are maintained according to the Safety Codes Act.

ii) To co-ordinate government inspections efficiently, reduce duplication, and to facilitate government agencies working towards assisting each other.

iii) To emphasize that EUB staff, while willing to assist, are not trained specialists in the area of electrical inspections, and in no way should their inspection be construed as a complete and thorough inspection of the electrical system.

iv) To ensure it is understood by this willingness to assist, the EUB is in no way assuming jurisdiction of electrical systems.

v) To ensure the EUB and its staff are protected from the potential of court actions as a result of trying to assist a member of our government family.

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Alberta Energy and Utilities Board
640 - 5 Avenue SW
Calgary, AB T2P 3G4

Appendix 15

EUB Alberta Energy and Utilities Board

Field Inspection Branch ERP Review

Licensee ____________ Facility Type ____________ Facility name ____________
Date ____________ Field Centre ____________ Inspector ____________

Mandatory

The following six requirements must be met to achieve a satisfactory inspection regarding emergency response planning:

	Yes	No	N/A
1. Is there a site-specific emergency response plan (ERP) where required?			
2. Is safety equipment specified in the ERP installed?			
3. Is a copy of the ERP readily available on site?			
4. Is the ERP updated yearly, with yearly exercises held and details documented?			
5. Is licensee/operator on-site representative familiar with the ERP?			
6. Does licensee/operator communicate regularly with residents in the emergency response zone (EPZ)?			

Supporting Information

The following seven criteria must be reviewed with the licensee's representative to gauge operator awareness and ERP competencies. These criteria will assist the inspector in determining the rating for the above requirements. Criteria 7: Resident Contact must be confirmed by a minimum of two resident contacts per ERP. The resident contact form must also be completed.

1. Location and reporting
2. Responsibilities of company personnel
3. Monitoring and isolating the hazard area
4. Evacuation procedures
5. Ignition guidelines
6. Communication
7. Resident contact

1. Location and Reporting— Does the ERP	Yes	No	N/A
a) identify facilities covered by the plan?			
b) provide legal descriptions and maps detailing EPZs and resident locations (including trappers and places of business)?			
c) include a comprehensive list of all wells, pipelines, and production facilities, including maximum potential release rates or volumes and the corresponding planning zones?			
d) describe how incidents are reported to EUB and outside agencies?			
e) describe levels of alert so that they are clearly understood?			

2. Responsibilities of Company Personnel— Does the ERP	Yes	No	N/A
a) identify personnel responsible for initiating emergency procedures?			
b) outline responsibilities of key individuals?			
c) identify names and telephone numbers of key individuals (especially in the emergency phone list)?			
d) identify alternate/backup personnel?			

3. Monitoring and Isolating the Hazard Area—Does the ERP	Yes	No	N/A
a) describe monitoring devices and circumstances for handheld monitors (draeger units/personal monitors)?			
b) identify sources of mobile and stationary air monitoring units?			
c) describe procedures for blocking access routes by licensee and others (isolating hazard)?			

4. Evacuation Procedures—Does the ERP	Yes	No	N/A
a) outline methods and procedures for public evacuation and sheltering?			
b) include statement of information to be given to residents within the EPZ that describes location and nature of hazard?			
c) describe evacuation route(s)?			
d) identify the location and phone number of the evacuation centre?			
e) describe procedures for locating and ensuring the safety of transients and other industrial operators?			
f) list trapper and transient phone number(s) and address(es)?			
g) describe methods of transient surveys (hunters, etc.)?			
h) describe procedures for notification and evacuation of schools?			
i) describe procedures for calling down emergency status and resuming operations?			

(continued)

5. Ignition Guidelines—Does the ERP	**Yes**	**No**	**N/A**
a) identify personnel with authority to ignite release?	___	___	___
b) list criteria to be considered for ignition?	___	___	___

6. Communication— Does the ERP describe procedures for	**Yes**	**No**	**N/A**
a) establishing an on-site command post (OSCP)?	___	___	___
b) establishing an off-site emergency operations centre (Off-Site EOC)?	___	___	___
c) licensee to inform and update the public of the hazard?	___	___	___
d) communicating with the public and media through press releases?	___	___	___

7. Resident Contact—Has the licensee ensured that	**Yes**	**No**	**N/A**
a) resident contact has been made and/or maintained?	___	___	___
b) an information package has been given to residents?	___	___	___
c) the information package describes characteristics and hazards of H_2S and SO_2?	___	___	___
d) the information package describes key actions/responses in an emergency?	___	___	___
e) the information package provides 24-hour company telephone number(s)?	___	___	___

Based on the above criteria, rate the licensee's enforcement for compliance/noncompliance status as detailed in *Guide 36*, *Guide 37*, *Guide 64*, and *Guide 66*. Document the results on the appropriate Drilling And Servicing Inspection Report using the criteria listed below. Attach this review to the licensee's file in the appropriate Field Centre.

Legend: **X - Satisfactory** **U - Minor** **M - Major** **S - Serious**

S	No approved site-specific ERP where required.
S	Safety equipment specified in ERP not installed.
M	Copy of ERP not readily available.
M	ERP manual not updated yearly, and exercises not held or details not documented.
M	Operator on-site representative not familiar with ERP.
U	Operator not communicating with residents in EPZ.

Appendix 16

PUBLIC CONTACT FORM

Date: ____________________

Facility Name: ____________________ **Facility Code:** __________

Location: ____________________

Licensee: **Licensee Code:** __________

Field Centre:

BV-05	☐	MH-08	☐
DV-06	☐	MP-04	☐
GP-10	☐	RD-09	☐
SA-07	☐	WW-03	☐

Does the facility have an approved ERP? Y/N

Type of Facility/Operation:

Battery ☐ Pipeline ☐
Gas Plant ☐ ENVIR ☐
Drlg./Serv.Well ☐

Inspection Results

Was inspection of facility/operation satisfactory?	Yes / No
Was resident(s) informed of EUB inspection results?	Yes / No

Contact Information (To be completed during visit or when resident contacts inspector by phone.)

Resident Name: ______________________________

Address: ______________________________

Phone Number: ______________________________

Was resident home?	Yes / No
If resident not home, was contact letter left?	Yes / No

ERP Information

Was resident(s) aware of EUB?	Yes / No
Is resident(s) aware of Industry contact?	Yes / No
Does facility/operation have an Emergency Response Plan?	Yes / No
Was resident(s) aware of the Emergency Response Plan?	Yes / No
Did resident(s) know what to do in the event of emergency?	Yes / No
Did resident(s) have any concerns? (If yes, identify below and complete ENV form if necessary.)	Yes / No
Was ENV form filled out?	Yes / No

Follow-up Required: (Note: A Major Unsatisfactory inspection requires 2 reinspections within 9 months.)

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Comments:

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Inspector:	Initials	Time Spent (mandays)

Appendix 17 References Cited and Further Reading

EUB Documents*

Internal Guide 8: Safety Manual
Guide 8: Surface Casing Depth Minimum Requirements
Guide 36: Drilling Rig Inspection Manual
Guide 37: Service Rig Inspection Manual
Guide 38: Noise Control Directive User Guide
Guide 50: Drilling Waste Management.
Guide 55: Storage Requirements for the Upstream Petroleum Industry
Guide 56: Energy Development Application Guide
Guide 58: Oilfield Waste Management Requirements for the Upstream Petroleum Industry
Guide 59: Well Drilling and Completion Data Filing Requirements
Guide 60: Upstream Petroleum Industry Flaring Guide
Guide 63: Oilfield Waste Management Facility Inspection Manual
Guide 64: Facility Inspection Manual

ID 91-2: Corporate-Level Emergency Response Plans
ID 91-3: Heavy Oil/Oil Sands Operations
ID 94-3: Underbalanced Drilling
ID 96-3: Oilfield Waste Management Requirements for the Upstream Petroleum Industry
ID 97-6: Sour Well Licensing and Drilling Requirements
ID 98-3: Well Records—Data Summary Forms
ID 99-4: Deposition of Oilfield Waste into Landfills
ID 99-5: Disposal of Drilling Waste Associated with Alberta Energy and Utilities Board (EUB) Regulated Pipeline and/or Other Oil and Gas Related Below Ground Boring Activities
ID 99-8: Noise Control Directive
ID 2000-3: Harmonization of Waste Management and Memorandum of Understanding between the Alberta Energy and Utilities Board and Alberta Environment
ID 2000-4: An Update to the Requirements for the Appropriate Management of Oilfield Wastes

IL 88-17: Ignition Equipment for Drilling Critical Sour Wells
IL 89-15: Evacuation and Ignition for Sour Wells
IL 98-1: A Memorandum of Understanding between Alberta Environmental Protection and the Alberta Energy and Utilities Board Regarding Coordination of Release Notification Requirements and Subsequent Regulatory Response
IL 99-4: EUB Enforcement Process, Generic Enforcement Ladder, and Field Surveillance Enforcement Ladder

Acts and Regulations

Energy Resources Conservation Act
Oil and Gas Conservation Act
Oil and Gas Conservation Regulations

Other Documents

American Petroleum Institute (API) Bulletin 5A2: Bulletin on Thread Compounds
API RP 5C1: Care and Use of Casing and Tubing
API RP-53: Recommended Practices for Blowout Prevention Equipment Systems for Drilling Wells
API Specification 6A: Specification for Wellhead and Christmas Tree Equipment (13th edition)
API Specifications 16A: Drill-Through Equipment
American Society of Mechanical Engineers (ASME): Boiler and Pressure Vessel Code, Section IX
Canadian Standards Association (CSA) Z184: Standards for Gas Pipeline Systems
Industry Recommended Practice (IRP) Volume 1: Industry Recommended Practices for Drilling Critical Sour Wells
IRP Volume 3: Heavy Oil and Oil Sands Operations
IRP Volume 4: Well Testing and Fluid Handling
IRP Volume 8: Pumping of Flammable Fluids
IRP Volume 14: Non Water Based Drilling and Completions Fluids, National Association of Corrosion Engineers (NACE) MR0175: Standard Material Requirements—Sulphide Stress Cracking Resistant Metallic Material for Oilfield Equipment
NACE TM 0187-87: Standard Method for Evaluating Elastomeric Materials in Sour Gas Environments
Petroleum Industry Training Service (PITS) First Line Supervisor's Blowout Prevention
PITS Second Line Supervisor's Blowout Prevention

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* EUB documents are available on the EUB Web site <www.eub.gov.ab.ca> or from EUB Information Services, 640–5 Avenue SW, Main Floor, Calgary AB T2P 3G4; Tel: (403) 297-8190; Fax: (403) 297-7040.